



Inventor and Word No.1 Manufacturer of
Picture Framing Machines & Consumables Since 1976

MACH 4CART

Automatic Underpinner



Read Carefully before using the machine

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INDEX

I. USER MANUAL / ENGLISH.....	6
1 PRESENTATION	7
1.A WORK TABLE	7
1.B INTRODUCTION	9
1.C ACCESSORIES SUPPLIED WITH THE MACHINE	9
1.D TECHNICAL SPECIFICATIONS OF MACH 4 CART	10
1.E OPTIONS.....	10
1.F GUARANTEE	10
2 SETUP	11
2.A. UNPACKING THE MACHINE	11
2.A AIR LINE FITTINGS	12
2.B CONNECTING TO THE AIR SOURCE.....	12
3 STARTING UP	14
3.A PLUGGING THE MACHINE	14
3.B LANGUAGE SELECTION.....	14
4 ADJUSTMENTS	15
4.A ADJUSTMENT OF THE SLIDING TABLE	15
4.B PROPER ADJUSTMENT OF MAGNETIC ADJUSTABLE ROD CLAMP	15
4.C SPECIFIC USE OF THE SPACER BARS	16
4.D SELECTING THE WEDGES POSITIONS	17
4.E THREE ESSENTIAL RULES	17
4.F ADJUSTING THE JOINING ANGLE.....	17
4.G MEANS OF JOINING.....	18
4.H LOADING OF CARTRIDGE WEDGES.....	18
4.I CHANGING WEDGES SIZE	19
5 PROGRAMMING THE MACHINE	20
5.A ADVANCED SCREEN: PROGRAMMING A PROFILE	20
5.B ADVANCED SCREEN: MEMORISING A PROFILE	22
5.C ADVANCED SCREEN: RECALLING A MEMORISED ARTICLE	23
5.D ADVANCED SCREEN: PREPARING THE EXECUTION	24
5.D.a Selecting the stapling mode	24
5.D.b Selecting the speed.....	24
5.D.c Resetting the counter	24
5.E ADVANCED SCREEN: REVIEW OF ALL BUTTONS.....	25
5.F SIMPLE SCREEN: PROGRAMMING A PROFILE	26
5.G SIMPLE SCREEN: MEMORISING A PROFILE.....	27
5.H SIMPLE SCREEN: PREPARING THE EXECUTION.....	29
5.H.a Selecting the stapling mode	29
5.H.b Selecting the speed.....	29
5.H.c Resetting the counter	29
5.I SIMPLE SCREEN: REVIEW OF ALL BUTTONS.....	30
5.J USE OF REGULATORS.....	30
6 SCREENS AND OPTIONS:	31
6.A ARTICLES SCREEN	31
6.B SETTINGS SCREEN.....	32

6.B.a	Page 1: maintenance alarm	32
6.B.b	Page 2: counter configuration	33
6.B.c	Page 2: fine tuning of the shooting position.....	33
6.B.d	Page 2: changing the language of the machine	33
6.B.e	Page 3: setting date and time	34
6.B.f	Page 3: choosing the favorite execution screen	34
6.B.g	Page 3: overriding wedge sensor:.....	34
6.B.h	Page 3: reading the statistics	34
6.B.i	Page 3: configuring the manual mode.....	35
6.B.j	Page 4: Reading input/outputs	35
6.B.k	Page 5: database management	35
6.B.l	Page 6: barcode management:.....	38
6.C	ARTICLE LIST SCREEN:.....	38
6.D	NETWORK MENU	39
7	MAINTENANCE	41
7.A	SAFETY INSTRUCTIONS.....	41
7.B	MAINTENANCE PLAN	41
7.B.a	Daily maintenance:	41
7.B.b	Regular maintenance:.....	41
7.B.c	Every 6 months:.....	42
7.C	REMOVING THE DISTRIBUTOR HEAD	42
7.D	LUBRICATING THE DISTRIBUTOR HEAD.....	43
7.E	UNJAMMING THE MACHINE	43
7.F	RESETTING THE MAINTENANCE ALARM	44
7.G	REMOVING THE SIDE PANEL	44
7.H	LUBRICATING THE HORIZONTAL COLUMNS.....	45
7.I	TESTING THE SAFETIES OF THE MACHINE	45
7.J	TROUBLE SHOOTING	46
II.	MANUEL D'UTILISATION / FRANCAIS.....	48
1	PRESENTATION	49
1.A	TABLE D'ASSEMBLAGE	49
1.B	INTRODUCTION	51
1.C	ACCESSOIRES FOURNIS AVEC LA MACHINE.....	51
1.D	SPECIFICATIONS TECHNIQUES.....	52
1.E	OPTIONS.....	52
1.F	GARANTIE.....	52
2	MISE EN ROUTE.....	53
2.A	DEBALLAGE DE LA MACHINE.....	53
2.B	RACCORDS.....	54
2.C	RACCORDEMENT A L'AIR COMPRIMÉ	54
3	DEMARRAGE DE LA MACHINE	56
3.A	RACCORDEMENT ELECTRIQUE DE LA MACHINE	56
3.B	SELECTION DE LA LANGUE	56
4	REGLAGES	57
4.A	REGLAGE DE LA TABLE COULISSANTE	57
4.B	REGLAGE DU PRESSEUR VERTICAL	57
4.C	UTILISATION DU JEU DE BARRETTES	58
4.D	SELECTION DES POSITIONS D'AGRAFAGE	59
4.E	TROIS REGLES ESSENTIELLES POUR L'ASSEMBLAGE.....	59
4.F	REGLAGE DE L'ANGLE D'ASSEMBLAGE.....	59
4.G	MOYEN D'ASSEMBLAGE	60

4.H	CHARGEMENT DES AGRAFES	60
4.I	CHANGER DE TAILLE D'AGRAFES	61
5	PROGRAMMATION	62
5.A	MODE AVANCE: PROGRAMMATION D'UN PROFILE	62
5.B	MODE AVANCE: MEMORISATION D'UN PROFILE	64
5.C	MODE AVANCE: RAPPEL D'UN ARTICLE MEMORISE	65
5.D	MODE AVANCE: PREPARATION A L'EXECUTION	66
5.D.a	Sélection du mode d'agrafage	66
5.D.b	Sélection de la vitesse	66
5.D.c	Mise à zero du compteur	66
5.E	MODE AVANCE: VUE D'ENSEMBLE DES BOUTONS	67
5.F	MODE STANDARD: PROGRAMMER UN PROFILE	68
5.G	MODE STANDARD: MEMORISATION D'UN PROFILE	69
5.H	MODE STANDARD: PREPARATION A L'EXECUTION	70
5.H.a	Sélection du mode d'agrafage	71
5.H.b	Sélection de la vitesse	71
5.H.c	Initialisation du compteur	71
5.I	MODE STANDARD: VUE D'ENSEMBLE DES BOUTONS	72
5.J	UTILISATION DES REGULATEURS	72
6	ECRANS ET OPTIONS:	73
6.A	MENU ARTICLES	73
6.B	PARAMETRES	74
6.B.a	Page 1: alarme maintenance	74
6.B.b	Page 2: configuration du compteur	75
6.B.c	Page 2: ajustage de la position d'agrafage	75
6.B.d	Page 2: changer la langue de la machine	75
6.B.e	Page 3: définir l'heure et la date	76
6.B.f	Page 3: définir le mode d'exécution favori	76
6.B.g	Page 3: désactiver le capteur d'agrafe	76
6.B.h	Page 3: statistiques	76
6.B.i	Page 3: configuration du mode manuel	77
6.B.j	Page 4: lecture des entrées/sorties	77
6.B.k	Page 5: gestion de la base de données	77
6.B.l	Page 6: utilisation du code à barres	80
6.C	LISTE ARTICLES	80
6.D	NETWORK MENU	81
7	MAINTENANCE	82
7.A	INSTRUCTIONS RELATIVES A LA SECURITE	82
7.B	PROGRAMME DE MAINTENANCE	82
7.B.a	Maintenance quotidienne:	82
7.B.b	Maintenance préventive:	82
7.B.c	Tous les six mois:	83
7.C	DEMONTAGE DE LA TETE DE DISTRIBUTION	83
7.D	LUBRICATION DE LA TETE DE DISTRIBUTION	84
7.E	DEBLOCAGE DE LA MACHINE	84
7.F	EFFACEMENT DE L'ALARME MAINTENANCE	85
7.G	DEMONTAGE DES PANNEAUX LATERAUX	85
7.H	LUBRIFICATION DES COLONNES HORIZONTALES	86
7.I	VERIFICATION DES SECURITES DE LA MACHINE	86
7.J	GUIDE DE DEPANNAGE	87

III. EXPLODED VIEWS/ VUE ECLATEES 89

IV. SPARE PARTS LIST / NOMENCLATURE	103
V. ELECTRICAL SCHEMATICS / SCHEMAS ELECTRIQUES	110
VI. CE CERTIFICATE / DECLARATION DE CONFORMITE	117

I. USER MANUAL / ENGLISH

Your safety is our priority



This symbol on the machine reminds the operator to wear acoustic protections before operating this joiner.



This symbol on the machine reminds the operator to read this manual before operating this joiner.



This symbol in the manual is to mention safety instructions.



This symbol in the manual is to mention some tricks that can help you saving time or improve your production.



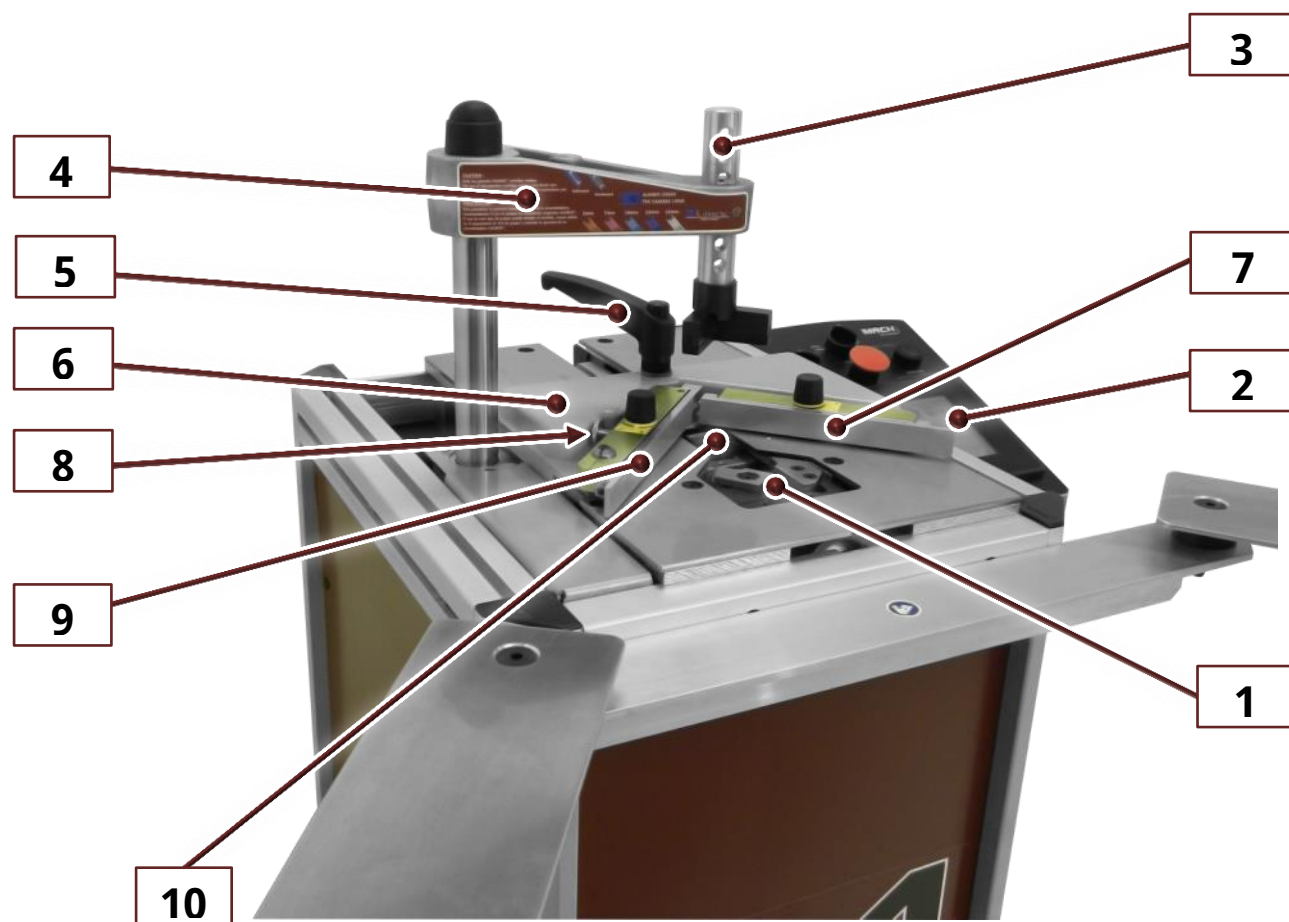
This symbol in the manual is to mention needed tools to perform a procedure.

English

PRIOR TO PERFORM ANY MAINTENANCE, MACHINE MUST BE LOCKED AND UNPLUGGED FROM POWER SOURCES (AIR AND ELECTRICITY), REFER TO CHAPTER I.7.A SAFETY INSTRUCTIONS (PAGE 41). DO NOT OPERATE THE MACHINE IF COVERS OR PROTECTIONS ARE MISSING.

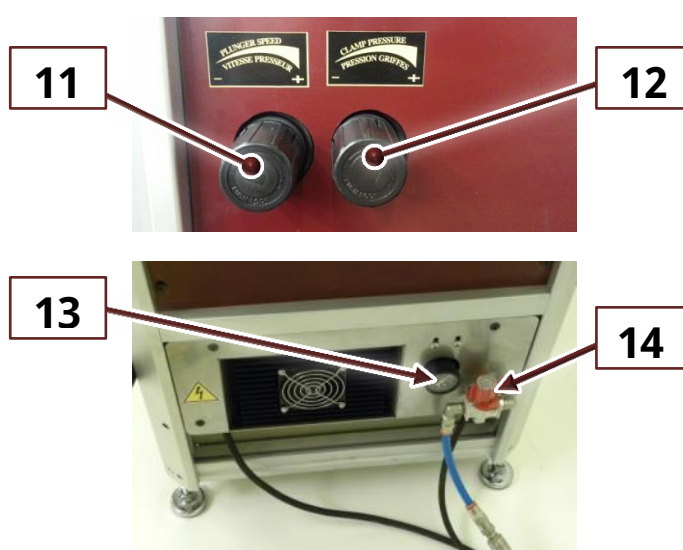
1 PRESENTATION

1.A WORK TABLE



English

Rebate clamp	1
Touch screen	2
Magnetic adjustable rod clamp assembly	3
Crossbar	4
Sliding table handle	5
Sliding table	6
1 st back fence	7
Angle adjusting screw	8
2 nd back fence	9
Wedge distributor	10
Plunger speed regulator	11
Clamp pressure regulator	12
Air pressure gauge	13
Air valve	14





English

Loading button	15
Pre-clamp button	16
Stapling button	17
Emergency/stop & start button	18

1.B INTRODUCTION

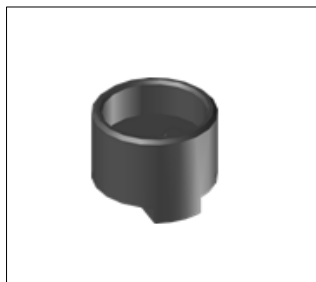
Thanks for having purchased the MACH 4 CART underpinner and for your trust in Cassese® products. The MACH 4 CART benefits from Cassese's experience since 1976 in designing and manufacturing highest quality underpinners, for which we are world-famous.

The MACH 4 CART will allow you to join, wooden, plastic and MDF profiles (patent n° 7522814). Joining operation is carried out by using Genuine Cassese® Cartridge Wedges, specially designed to perform perfect and tight frames' corners.

1.C ACCESSORIES SUPPLIED WITH THE MACHINE



Z26999:
1 x Magnetic adjustable rod clamp



Z24703:
1 x Chevron holder



Z21524:
1 x Chevron rubber



Z506:
1 x Wedge driver blade for using CASSESE® Genuine Cartridge Wedges



Z1879:
1 x Allen Key 2.5 mm



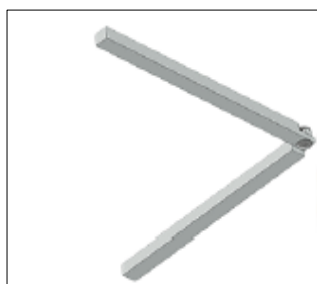
Z1882:
1 x Allen Key 3 mm



Z1884:
1 x Allen Key 4 mm



Z1885:
1 x Allen Key 5 mm



Z3078:
Spacer bars



Z1896:
1 x Grease Tube



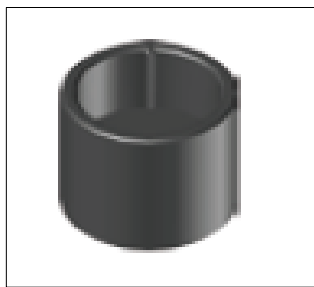
1 box of 7 mm Softwood
1 box of 10mm Hardwood
1 box of 10mm Softwood



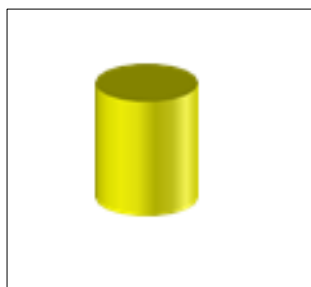
Z535:
Wedge removal tool



Z1791:
Green round clamp



Z18065:
Round clamp holder



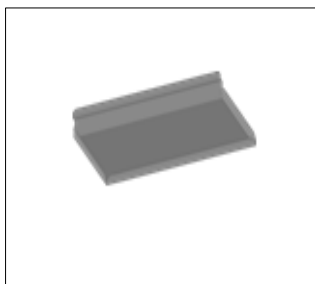
Z1783:
Yellow round clamp

1.D TECHNICAL SPECIFICATIONS OF MACH 4 CART

<u>Minimum moulding width:</u>	5mm (3/16") / Minimum moulding height : 7 mm (1/4")
<u>Maximum moulding width:</u>	150 mm (5 29/32") / Maximum moulding height : 100 mm (4 13/32") Maximum stroke between first and last wedge (at 45°) : 190 mm (7 31/64")
<u>3 wedge types :</u>	Softwood, Hardwood & MDF. Use only Cassese® Genuine Cartridge Wedges. Cassese® Genuine Cartridge Wedges sizes: 5, 7, 10, 12 and 15 mm.
<u>Machine gross weight :</u>	97 kg .
<u>Dimensions :</u>	Width 668mm (2ft 2 19/64") x Depth 589mm (1ft 11 13/16") x Height 1171mm (3ft 10 7/64").
<u>Power supply:</u>	110/230V, 50/60 Hz, single-phase, Consumption : 500W.
<u>Air Supply:</u>	compressed air 6-7 bars
<u>Average consumption per cycle :</u>	2 NI at 6 bars (we consider one cycle is a corner with 2 positions and 1 wedge per position)

English

1.E OPTIONS



Z25147:
Stainless steel shelf for
wedges and accessories



Barcode reader (Contact
the customer service)

1.F GUARANTEE

One year guarantee for parts and labor against manufacturing defects. Wearing parts* and those damaged as a result of non-appliance with the instructions of the present manual are excluded from the guarantee.

**Chevron rubbers, round clamps and wedge driver blades are considered as wearing parts.*

2 SETUP

2.A. UNPACKING THE MACHINE



Cutter
Flat span N.13 & N.17
Allen key N.5

Bubble level

Cut both plastic strips in order to free the box and lift up the wood cover with the help of a second person.



Figure 2-2

Remove the 4 bolts to free the machine from the crate. They are located under the pallet.



Figure 2-1

After unpacking the machine, install and set the 4 feet to level the machine. Make sure the 4 feet are touching the floor, machine must be steady.



Figure 2-3

The screen is hold in place with 3 screws.

2 are located on top of the screen.



Figure 2-4

One is located under the screen.

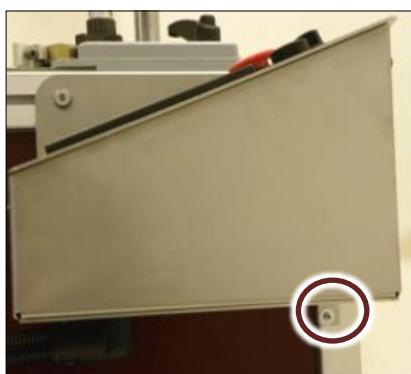


Figure 2-6

The screen can be installed on the other side of the machine using these screws.



Figure 2-5





When levelling the machine, if the machine is installed against a working table, make sure a long frame will not be risen up by the table, because this would cause bad joining. Working table and machine should be levelled together.

English



When installing the machine, make sure the floor will be flat and strong enough to support its weight. It should be installed in a dry environment providing temperate temperature. The floor should be flat and clean. Select a location with proper lighting.

2.A AIR LINE FITTINGS

	Included in the machine	Customer's air connection
Quick release(Q/R) Female	Standard hose connector - Z556	
Air Connector - Z749	Q/R US male connector - Z701	

2.B CONNECTING TO THE AIR SOURCE

English

The machine should be connected to a pneumatic circuit providing 6 to 8 bars pressure.

Connect the machine using the quick connectors as mentioned in chapter I.2.A



Figure 2-7

The MACH 4 CART must be connected to the air source located on the front panel of the drawer. Turn the compressed air valve to **ON** by rotating its red knob .

The air pressure gauge should show 6 bars (85 p.s.i.) minimum.



Figure 2-8



The red knob in Figure 2-8 can be used to secure the machine during maintenance or to prevent non desired use. A lock can be applied to it in stop position so nobody can turn it back to ON. This will exhaust air from the machine circuit and disconnect it from air supply, but it WILL NOT switch off electrical components. Refer to chapter I.7.A SAFETY INSTRUCTIONS (page 41) for further instructions.

If the indicated pressure is not 6 bars (85 p.s.i.), check the pressure at the air source (compressor). Then, if pressure is correct at the air source, it means the regulator of the machine needs fine tuning. Perform the following procedure to adjust it (Figure 2-9 and Figure 2-10)



Allen key N.3

Unscrew both screws of the drawer panel with a 3mm Allen key. Then open the drawer to have access to the air pressure regulator knob.

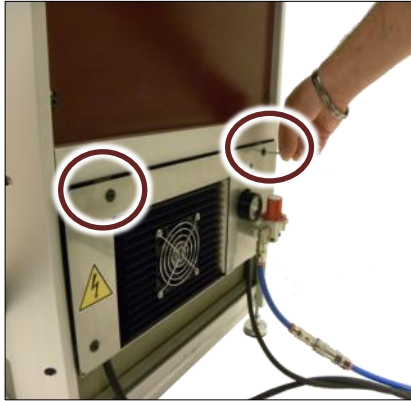


Figure 2-9

Pull up the air pressure regulator knob and turn it (clockwise = more pressure) until the needle of the air pressure gauge reaches 6 bars (85p.s.i.).

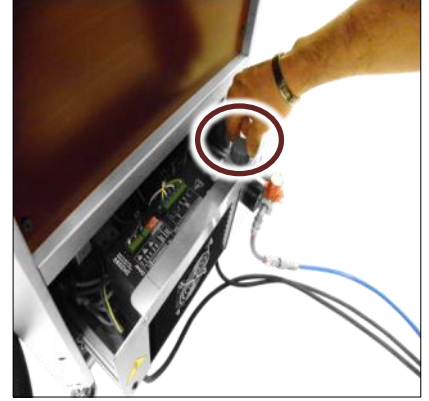


Figure 2-10

3 STARTING UP

3.A PLUGGING THE MACHINE

Connect the electrical plug of the MACH 4 CART to a grounded 220/110V single-phase outlet.



Figure 3-1

Switch on the MACH4 CART, by rotating the emergency STOP & START BUTTON



Figure 3-2



Prior to perform any maintenance always unplug the machine from the wall socket, if the red button is pushed it will still leave some alive wires inside the machine. Refer to chapter 1.7.A SAFETY INSTRUCTIONS (page 41) for safety instructions. The machine should be connected to a protected electrical supply according to the laws in your country (surge and earth protection). Please have a professional electrician checking your installation in case of doubt.

English

3.B LANGUAGE SELECTION

This screen will come up when machine will start. Some statistics showing amount of Vnails and corners (called cycles) done by the machine are also displayed.



Figure 3-3

Select your language by touching the flag in bottom right corner of the screen. Press several times on that flag until the requested language is displayed.



Figure 3-4

Touch the screen anywhere else to enter the execution screen.



Figure 3-5

4 ADJUSTMENTS

4.A ADJUSTMENT OF THE SLIDING TABLE

The sliding table (see page 7) needs to be adjusted to be able to set the various stapling positions.

To do this, switch on the Pre-Clamp button.



Figure 4-1

Unscrew the sliding table handle.



Figure 4-2

Shift the sliding table in order to tighten both mouldings with the rebate clamp (see page 7).

Then tighten the sliding table handle.



Figure 4-3

Switch back off the Pre-Clamp button in order to release the mouldings and remove the moulding that was against the back fence.



Figure 4-4

English

4.B PROPER ADJUSTMENT OF MAGNETIC ADJUSTABLE ROD CLAMP

A magnetic adjustable rod clamp comes with your machine as a standard feature. It fits the crossbar thanks to the locking ring and can be set at 1 to 7 positions.



Figure 4-5

Pull the black knob to be able to adjust the space between the vertical clamp and the top of the moulding. You must have 50mm (2") max between the clamp and the top of the moulding.

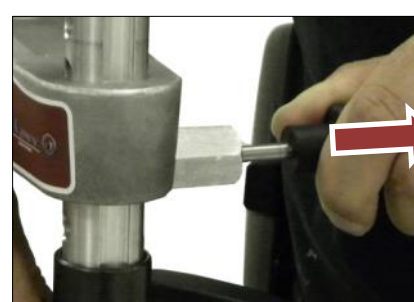


Figure 4-6



When adjusting the vertical rod clamp, closer it is from the top of the moulding, and faster will be the machine. The machine will not damage the moulding, even if the distance is very close. If the distance is superior to 50mm, the wedge will not penetrate fully inside the wood.

Pay attention to properly position the magnetic chevron clamp: the sides of the chevron must be parallel to back fences 1 and 2.

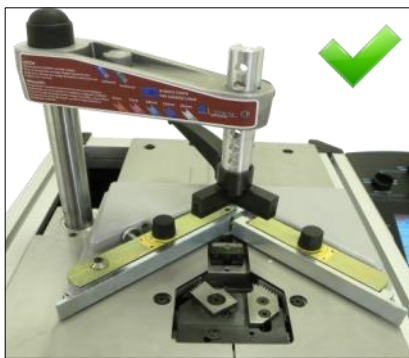


Figure 4-7

Example of bad setting of the chevron.

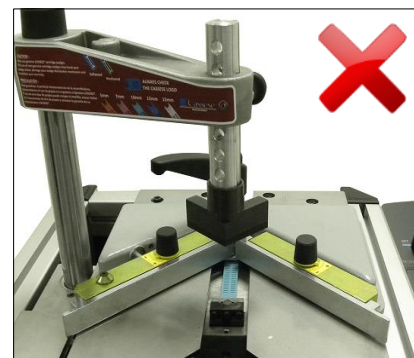


Figure 4-8

Now with quick-change magnetic clamps, it is easy to change from chevron to a round clamp. Simply pull down the Z24703 to change of clamp support.

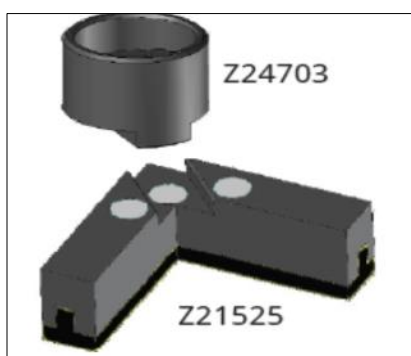


Figure 4-9

English

4.C SPECIFIC USE OF THE SPACER BARS

When joining small mouldings (lower than the height of the back fences), it is necessary to use the set of spacer bars supplied with the machine.

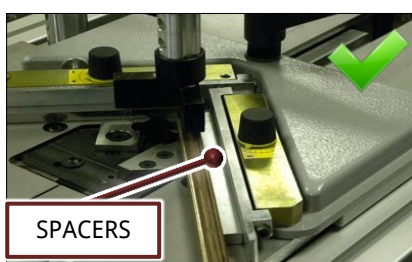


Figure 4-10

This is an example of a bad setting, the spacer bar not being used will cause the top clamp not to hold the moulding correctly. The moulding will jump up during stapling.

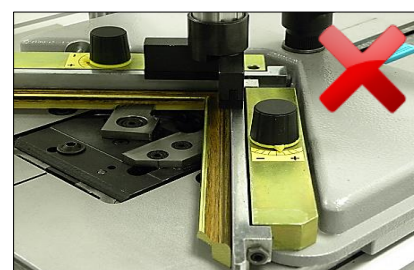


Figure 4-11

The spacer bars are made of two steel bars linked with a screw locked by a nut. The nut side is the bottom side of the spacer bars

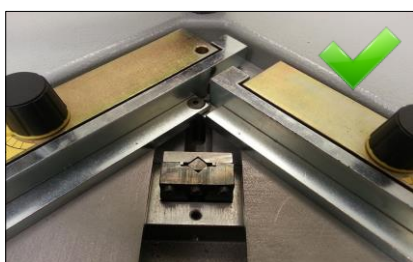


Figure 4-12

Here the spacer bars are upside down. The nut is visible on the top, which is not correct.



Figure 4-13

4.D SELECTING THE WEDGES POSITIONS

The MACH 4 CART is designed to join mouldings in 1 to 9 positions. You can stack up to 9 wedges in each position. The selection depends on the width and thickness of the moulding to join.

4.E THREE ESSENTIAL RULES

- 1- A MINIMUM 2 mm clearance (less than 1/8") above the wedges shall be respected.
- 2- Same size wedges can be stacked up in order to avoid having to change the wedge size when joining mouldings with different thickness.
- 3- The wedge positions should be lined up to the highest points of the moulding.

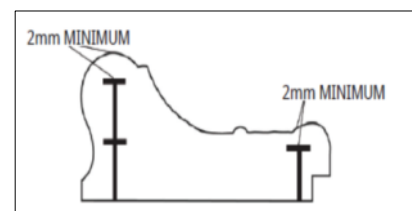


Figure 4-14



When selecting the position of the top clamp, always pay attention to its contact surface with the moulding. Select positions that will provide steady seating.

4.F ADJUSTING THE JOINING ANGLE

If the corner is opened towards outside

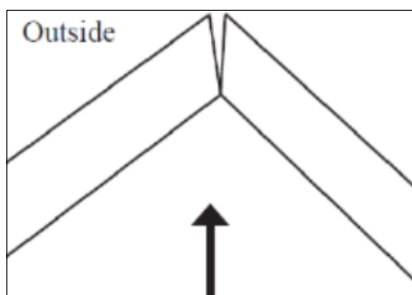


Figure 4-15

Tighten the adjusting screw to correct the defect of the mouldings.

Check the quality of the angle by clamping the corner against the back fences again.

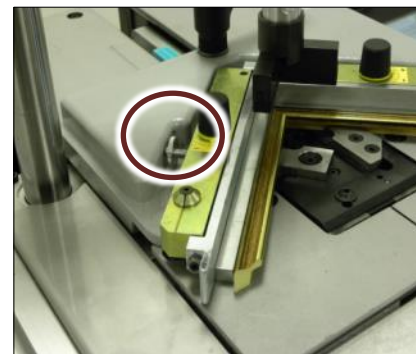


Figure 4-16

If the corner is opened towards inside.

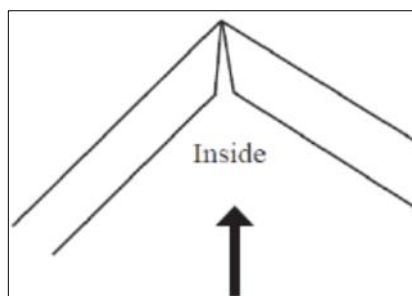


Figure 4-17

Loosen the adjusting screw to correct the defect of the mouldings.

Check the quality of the angle by clamping the corner against the back fences again.

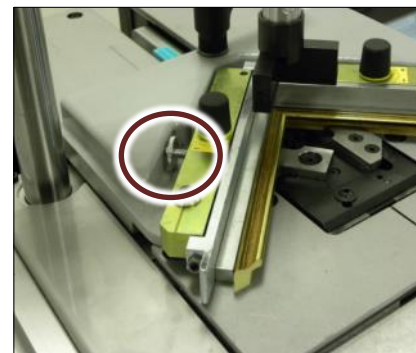


Figure 4-18

If you get this result : it means your cutting angle is less than 45°.

Your cutting machine needs to be set to the right 45° angle (check your cutting machine's user manual to make this adjustment).

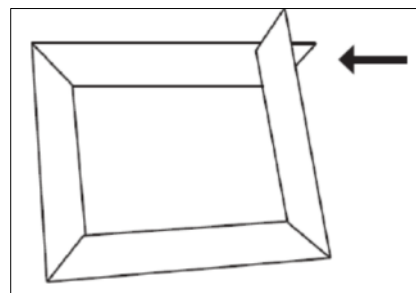


Figure 4-19

4.G MEANS OF JOINING

Thanks to the color code, you can recognize and select easily the type of Vnails to be used. Please note that hard wood Vnails will have a yellow pusher to help identifying them. A white pusher will indicate soft wood Vnails.

See color chart bellow for identification.

Cassese wedges can also be supplied in MDF type dedicated to MDF or very hard wood use. They are identified by a red pusher in the cartridge. Please contact your local agent to try them.

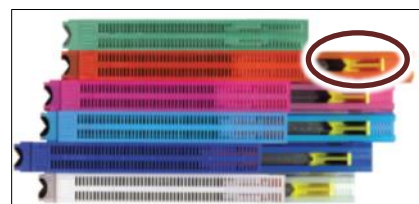


Figure 4-20

	BOX OF 6 CARTRIDGES		BOX OF 40 CARTRIDGES		
	SOFT WOOD	HARD WOOD	SOFT WOOD	HARD WOOD	MDF
15 mm wedges	30315NC01	31315BDC0	30415NC01	31415BDC0	31415MDF
12 mm wedges	30312NC01	31312BDC0	30412NC01	31412BDC0	31412MDF
10 mm wedges	30310NC01	31310BDC0	30410NC01	31410BDC0	31410MDF
7 mm wedges	30307NC01	31307BDC0	30407NC01	31407BDC0	31407MDF
5 mm wedges	30305NC01	31305BDC0	30405NC01	31405BDC0	
3 mm wedges	30303NC01		30403NC01		

English



It is recommended to use the proper type of wedges for joining, always using hard wood wedges in all your frame will result in poor tightening of the corner when the wood is soft. A first approach consists in trying to scratch the wood with your nails, if you can scratch it easily, then a soft wood wedge should do the job perfectly and you will get the best tightening.

4.H LOADING OF CARTRIDGE WEDGES

To load the machine, rotate the loading button in the load position.

The wedge pusher will move back to allow you to introduce the cartridge.



Figure 4-21

Load the cartridge and turn back the loading button to off.

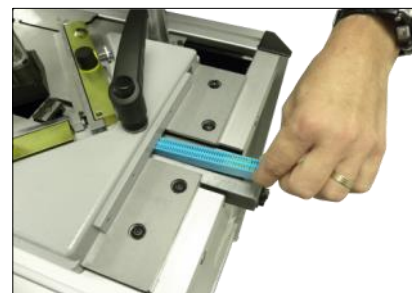


Figure 4-22

4.I CHANGING WEDGES SIZE

Repeat procedure of Figure 4-21, then remove the cartridge and insert another cartridge of a different color. Thanks to the cartridge system, no need to adjust anything or change any head.

Then turn back OFF the loading button.

5 PROGRAMMING THE MACHINE

After performing the adjustments of chapter 4 (ADJUSTMENTS). Perform the following procedure:

Put on the table only one chop of moulding against the fence.
This will allow easy visualization of stapling positions



Figure 5-1

Rotate the pre-clamping button in the ON position.



Figure 5-2

Depending of the configuration of the machine, when you will touch the screen for the first time after power up, two screens can come up. Both of them are showing the stapling parameters.

If this screen is displayed, please refer to chapter I.5.A ADVANCED SCREEN: PROGRAMMING A PROFILE (page 20). Your machine is showing the advanced screen.

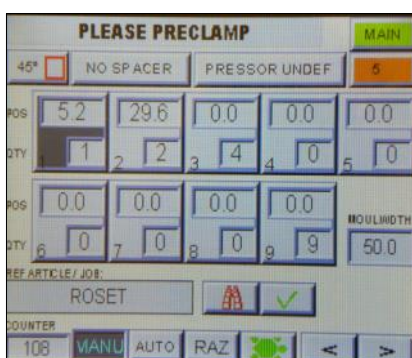


Figure 5-3

If this screen is displayed, please refer to chapter I.5.F SIMPLE SCREEN: PROGRAMMING A PROFILE (page 26).

Your machine is showing the simple screen.



Figure 5-4

5.A ADVANCED SCREEN: PROGRAMMING A PROFILE

Still with the pre-clamping button in ON position, press RAZ button to clear last job that was already in the memory of the machine.



Figure 5-5

Touch the number of the position you wish to program. Number one is the first position that will be executed, number 9 will be the last one. The MACH 4 CART can start from the back or from the front of the moulding.

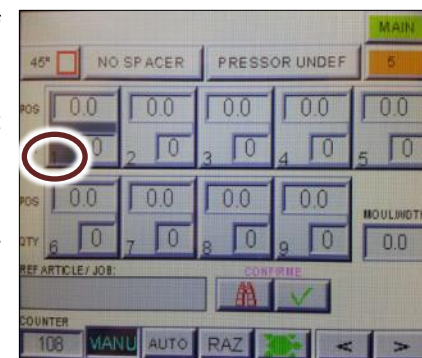


Figure 5-6

Touch the value of the corresponding position. A keyboard will be displayed to allow you to enter the desired position in millimeter.

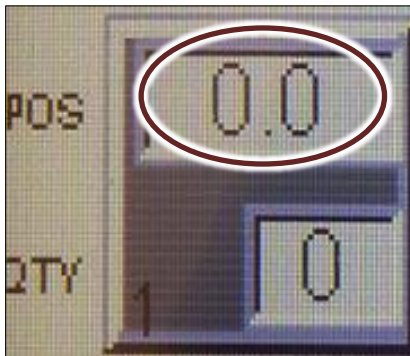


Figure 5-7

The value to be entered is in millimeters and should be measured from the rebate.

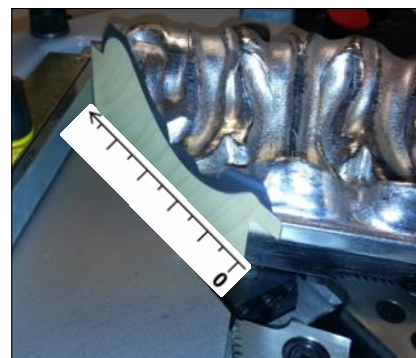


Figure 5-8

Once you have entered the desired position, press the **Enter** button to validate it. The keyboard will turn off.

CLR button can be used to clear the value if a mistake was done, **DEL** erases the last digit entered.



Figure 5-9

Using the same method, touch the amount of wedges to be inserted in the selected position and enter the desired value.

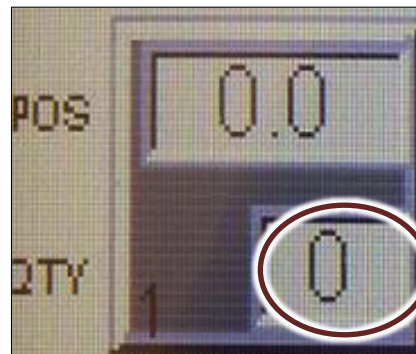


Figure 5-10

English

If a second position is needed, touch the number corresponding to the position to be programmed and proceed in the same way to enter the desired values.

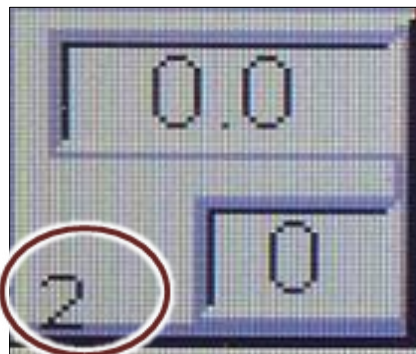


Figure 5-11

Instead of measuring the position and entering it with the keyboard, it is possible to move the shooting head step by step to the required position. This allows to check immediately that the position of the top clamp will be steady. Touch the number of the required position.

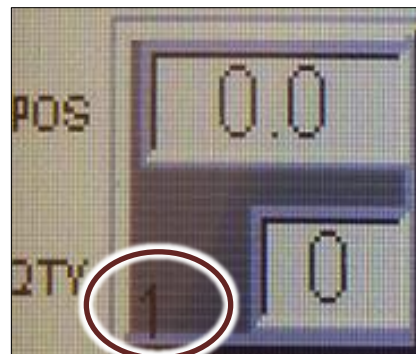


Figure 5-12

Use the two arrows to move the head in one way or the other until you reach the required position.

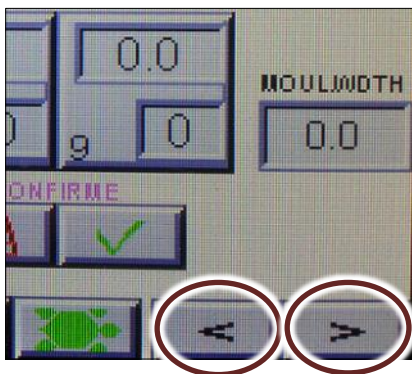


Figure 5-13

5.B ADVANCED SCREEN: MEMORISING A PROFILE

After having proceeded to the programming of the machine (refer to chapter 5.A ADVANCED SCREEN: PROGRAMMING A PROFILE page 20), it is possible to memorize the profile so it can be executed next time without having to program it again. Some extra parameters can also be set to ensure the operator is using proper accessories.

If the frame is octagonal or hexagonal type, then touch the 45° button several times until the right angle is set.

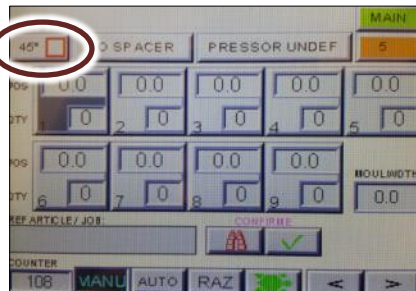


Figure 5-14

If the operator should use the spacer bars, touch the spacers button several times to achieve the right setting.

Refer to chapter I.4.C SPECIFIC USE OF THE SPACER BARS (page 16) to know when use of spacer is recommended.

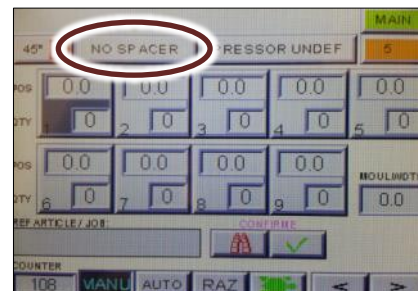


Figure 5-15

If you wish to memorize the type of top clamp to be used, touch that button several times until the correct top clamp is displayed.

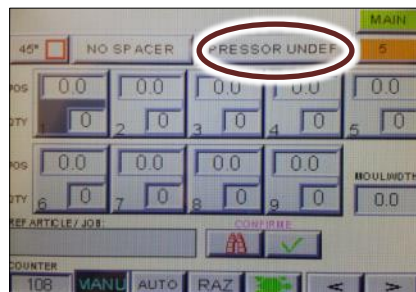


Figure 5-16

Select the correct size of wedge proceeding the same way.

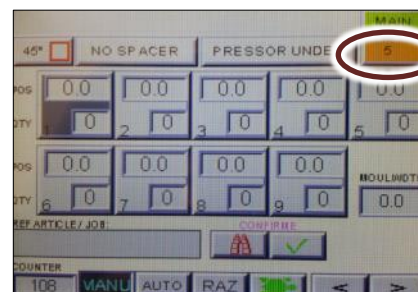


Figure 5-17

Enter the width of the moulding, by touching this button. A keyboard will be displayed to help you entering the needed value.

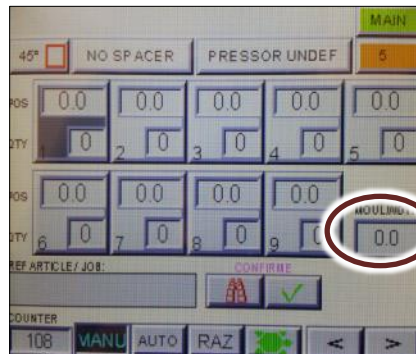


Figure 5-18

Touch that button to be able to give an article name to your profile. This name will be used to recall your profile in further joining.

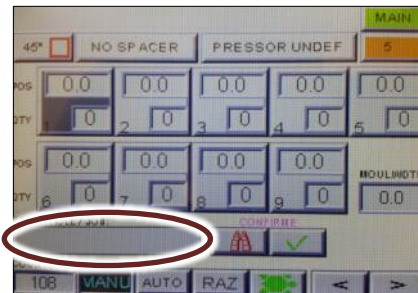


Figure 5-19

The keyboard will come up, use it to enter the desired name. Press the **ENT** button to validate it. The keyboard will turn off.

CLR button can be used to clear the value if a mistake was done, **DEL** erases the last digit entered.



Figure 5-20

Press this button to memorize the article in the memory of the machine.

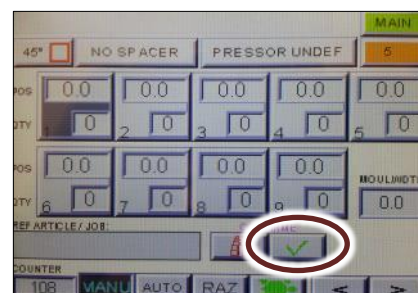


Figure 5-21



If the step Figure 5-21 is forgotten, the article won't be memorized, meaning it can be executed but it won't be available for further use.

5.C ADVANCED SCREEN: RECALLING A MEMORISED ARTICLE

If you wish to execute an article that was memorized previously, follow this procedure.

Touch that button to be able to enter an article to be executed.

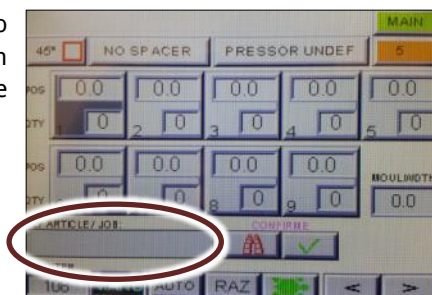


Figure 5-22

The keyboard will come up, use it to enter the desired name. Press the **ENT** button to validate it. The keyboard will turn off.

CLR button can be used to clear the value if a mistake was done, **DEL** erases the last digit entered.



Figure 5-23

Press this button to search the article in the memory of the machine.

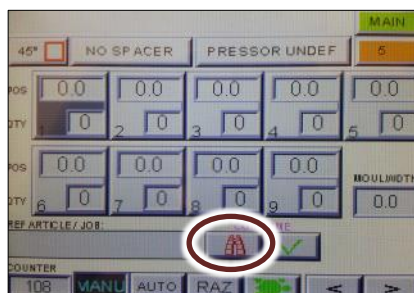


Figure 5-24

The machine will display the various accessories to be used, in this example:

- green round clamp
- 5mm wedges
- squareframe
- spacer bars are needed.

Once the accessories have been installed accordingly, press execute button to confirm.

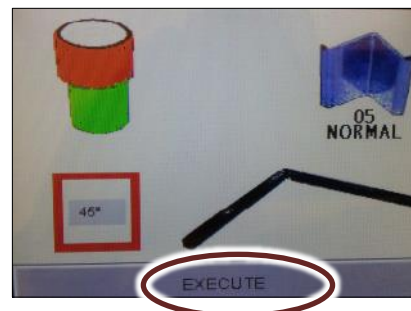


Figure 5-25

This screen will come up asking you to make the pre-clamping operation. Refer to chapter I.4.A ADJUSTMENT OF THE SLIDING TABLE page 15 to set the sliding table correctly.

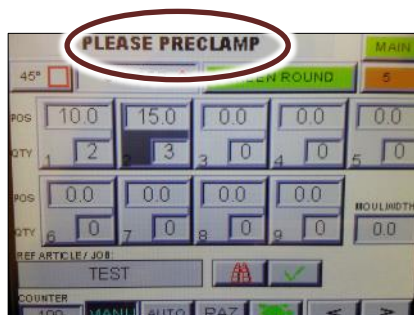


Figure 5-26

5.D ADVANCED SCREEN: PREPARING THE EXECUTION

Once the parameters are set correctly (chapter 5.A ADVANCED SCREEN: PROGRAMMING A PROFILE), you can then configure the execution.

5.D.a Selecting the stapling mode

Select the mode you would like to use for stapling. Press AUTO or MANU. The selected mode will remain black background.

MANUAL MODE : this mode will require two actions to get the corner done. Pressing the pedal will engage the front clamps to keep both mouldings together. You can then check the joining before launching the stapling with the stapling button. Manual mode will be selected by default at each power up of the machine.

AUTO MODE: this is the quickest mode, the machine will engage the front clamps and staple immediately when the pedal will be pressed.



Figure 5-27

5.D.b Selecting the speed

The vertical clamp speed can be adjusted depending on the hardness of the wood. Using that button will set the speed of the vertical clamp. Press that button to select turtle or rabbit mode.

TURTLE MODE : this mode will select a slower speed for the vertical clamp, it is useful for very soft moulding.

RABBIT MODE: Most of the time this mode will not cause any damage to the moulding and can be used to save time.

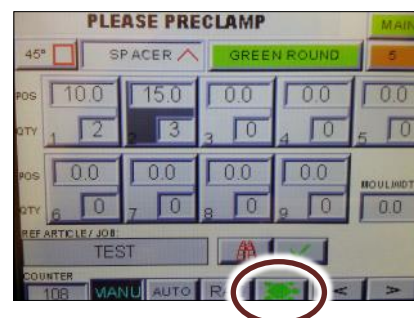


Figure 5-28

5.D.c Resetting the counter

Pressing this button will help to set the counter, a keyboard will appear allowing to reset it or to set it to a certain number.

If you set it at zero when starting production, you will see it increasing at each cycle so you know how many cycles were done. You can also configure it so it will decrease. Then entering the amount to be done in this field will allow you to see the remaining cycles to be done.

This counter can be set so it counts frames or corners.

Refer to chapter I.6.B.b Page 2: counter configuration (page 33) for configuration of that counter.

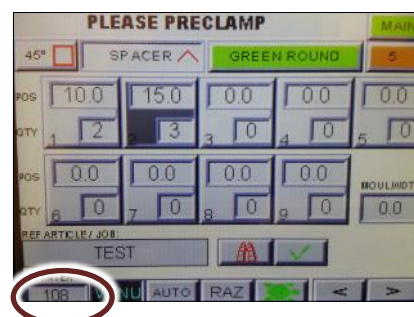
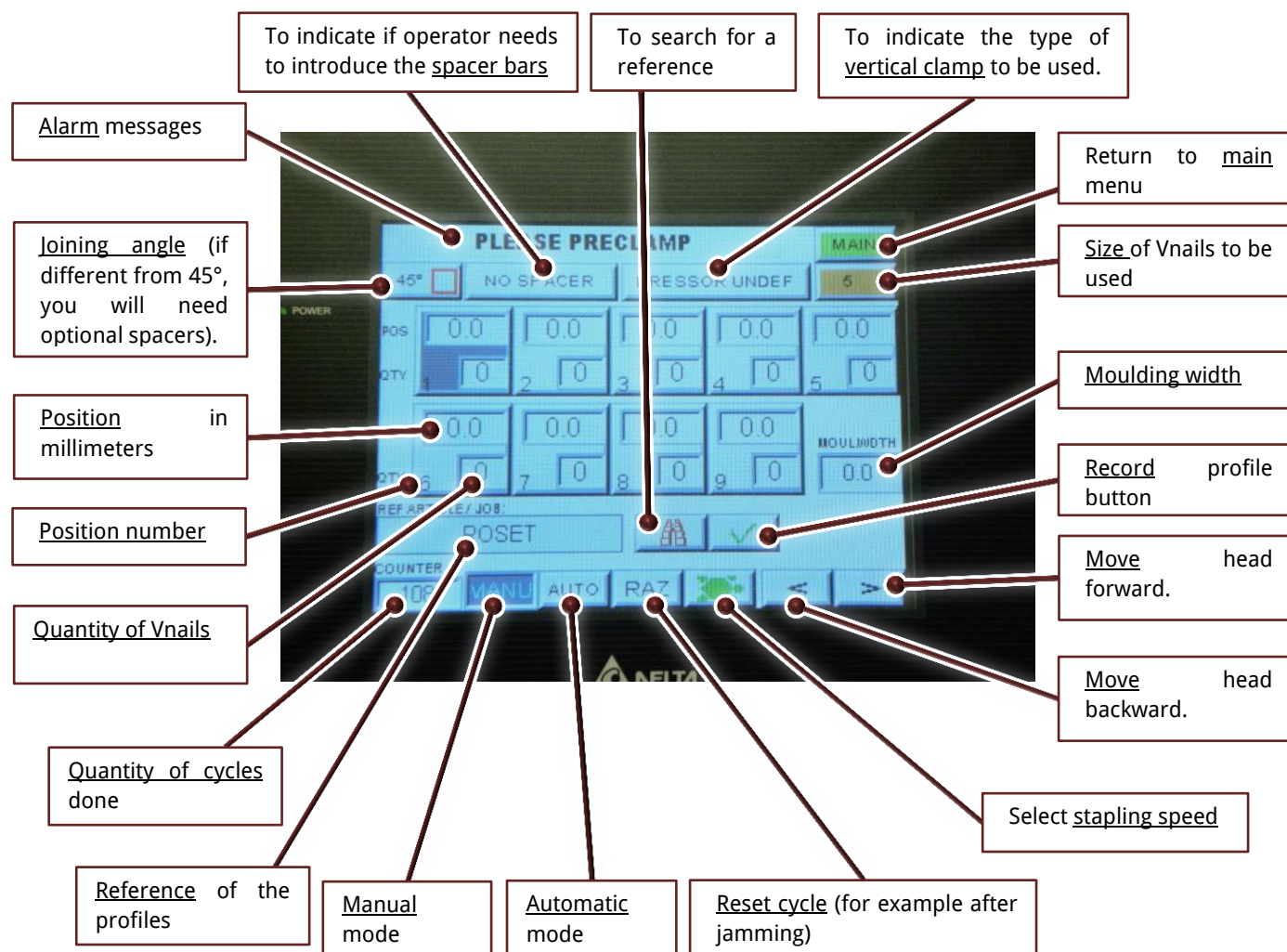


Figure 5-29

5.E ADVANCED SCREEN: REVIEW OF ALL BUTTONS

This screen will display the 9 positions in only one page, each position has a dedicated box labelled with its position number. No need to navigate in different pages to see the various positions programmed.



5.F SIMPLE SCREEN: PROGRAMMING A PROFILE

With the pre-clamping button still in ON position, press RAZ button to clear last job that was already in the memory of the machine.



Figure 5-30

Touch the button **POS** several time to achieve the position you wish to program. The number of the position is displayed on right side of this button. Number one is the first position that will be executed, number 9 will be the last one.



Figure 5-31

The MACH 4 CART can start from the back or from the front of the moulding.

Touch the value of the position. A keyboard will be activated to allow you to enter the desired position in millimeter.



Figure 5-32

The value to be entered is in millimeters and should be measured from the rebate.

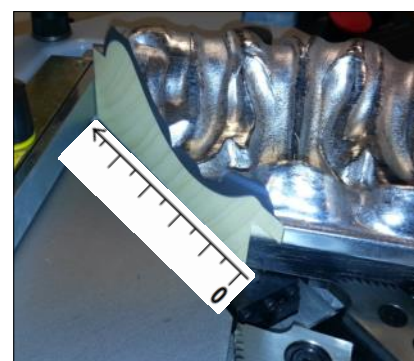


Figure 5-33

Once you have entered the desired position, press the **Enter** button to validate it. The keyboard will turn off.

CLR button can be used to clear the value if a mistake was done, **DEL** erases the last digit entered.

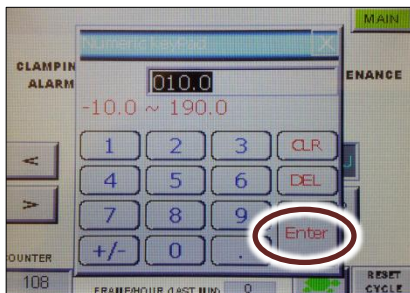


Figure 5-34

Using the same method, touch several times the amount of wedges to be inserted in the selected position until the desired value is displayed. Number of wedges is just on right side of the button.



Figure 5-35

Repeat same procedure from Figure 5-31 for other positions. Instead of measuring the position and entering it with the keyboard, it is possible to move the shooting head step by step to the desired position.



Figure 5-36

Use the arrows to get the head moving to the desired position.



Figure 5-37

It is also possible to go directly at a desired position by touching the position number. A keypad will allow you to select directly the position.



Figure 5-38

5.G SIMPLE SCREEN: MEMORISING A PROFILE

After having proceeded to the programming of the machine (refer to chapter 5.F SIMPLE SCREEN: PROGRAMMING A PROFILE page 26), it is possible to memorize the profile so it can be executed next time without having to program it again. This can't be done from the simple screen, but it can be done from advanced screen, even if the programming was done from the simple screen.



The simple and advanced screen are linked together, any modification in one screen will affect the other one, so you can swap at any moment from simple to advanced screen without losing your parameters.

English

Press the main menu button.



Figure 5-39

Then press the **ADVANCED** button or **STANDARD** button to return to the simple screen.

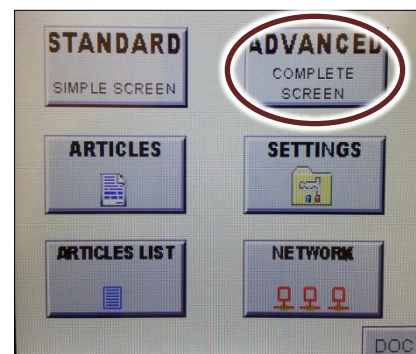


Figure 5-40

If the frame is octagonal or hexagonal type, then touch the 45° button several times until the right angle is set.

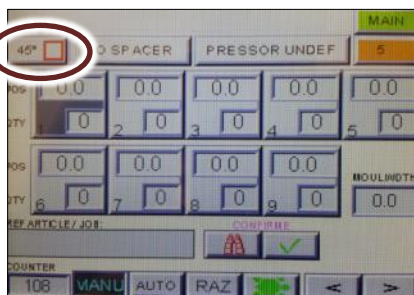


Figure 5-41

If the operator should use the spacers touch the spacer bars button several times to achieve the right setting.

Refer to chapter I.4.C SPECIFIC USE OF THE SPACER BARS (page 16) to know when use of spacer is recommended.

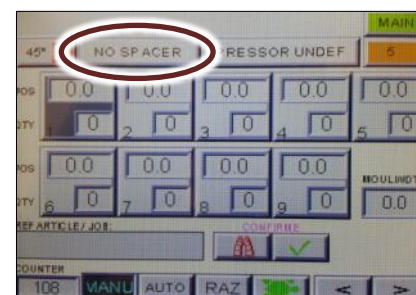


Figure 5-42

If you wish to memorize the type of top clamp to be used, touch that button several times until the correct top clamp is displayed.

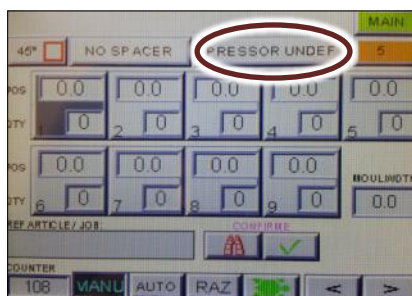


Figure 5-43

Select the correct size of wedge proceeding the same way.

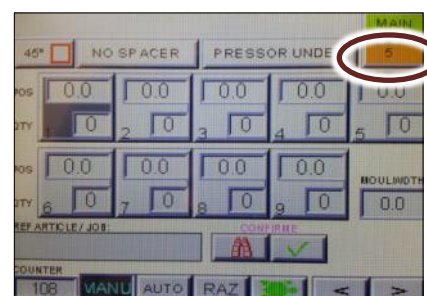


Figure 5-44

Enter the width of the moulding, by touching this button. A keyboard will come on to help you entering the needed value.

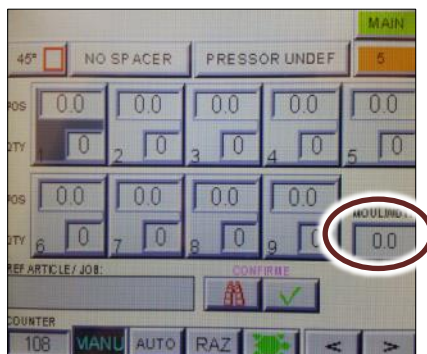


Figure 5-45

Touch that button to be able to give an article name to your profile. This name will be used to recall your profile in further joining.

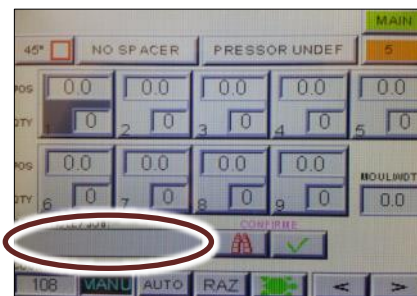


Figure 5-46

The keyboard will come up, use it to enter the desired name. Press the **ENT** button to validate it. The keyboard will turn off.

CLR button can be used to clear the value if a mistake was done, **DEL** erases the last digit entered.



Figure 5-47

Press this button to memorize the article in the memory of the machine.

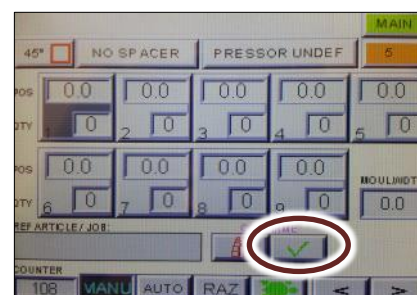


Figure 5-48



If the step of Figure 5-48 is forgotten, the article won't be memorized, meaning it can be executed but it won't be available for further use.

5.H SIMPLE SCREEN: PREPARING THE EXECUTION

Once the parameters are set correctly (see chapter 5.F SIMPLE SCREEN: PROGRAMMING A PROFILEpage 26), you can then configure the execution.

5.H.a Selecting the stapling mode

Select the mode you would like to use for stapling. Press AUTO or MANU The selected mode will remain black background.

MANUAL MODE : this mode will require two actions to get the corner done. Pressing the pedal will engage the front clamps to keep both mouldings together. You can then check the joining before launching the stapling with the stapling button. Manual mode will be selected by default at each power up of the machine.

AUTO MODE: this is the quickest mode, the machine will engage the front clamps and staple immediately when the pedal is pressed.

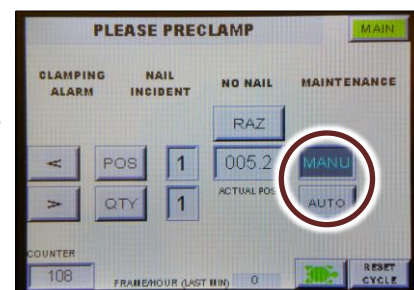


Figure 5-49

5.H.b Selecting the speed

The vertical clamp speed can be adjusted depending on the hardness of the wood. Using that button will set the speed of the vertical clamp. Press that button to select turtle or rabbit mode.

TURTLE MODE : this mode will select a slower speed for the vertical clamp, it is useful for very soft moulding.

RABBIT MODE: Most of the time this mode will not cause any damage to the moulding and can be used to save time.



Figure 5-50

5.H.c Resetting the counter

Pressing this button will help to set the counter, a keyboard will appear allowing to reset it or to set it to a certain number.

If you set it at zero when starting production, you will see it increasing at each cycle so you know how many cycles were joined. You can also configure it so it will decrease. Then entering the amount to be done in this field will allow you to see the remaining cycles to be done.

This counter can be set so it counts frames or corners.

Refer to chapter I.6.B.b Page 2: counter configuration (page 33) for configuration of that counter.

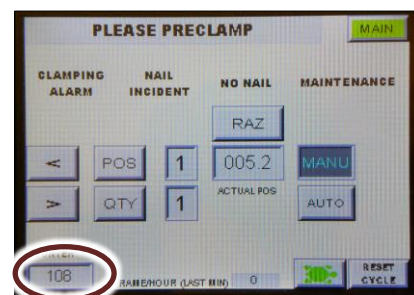
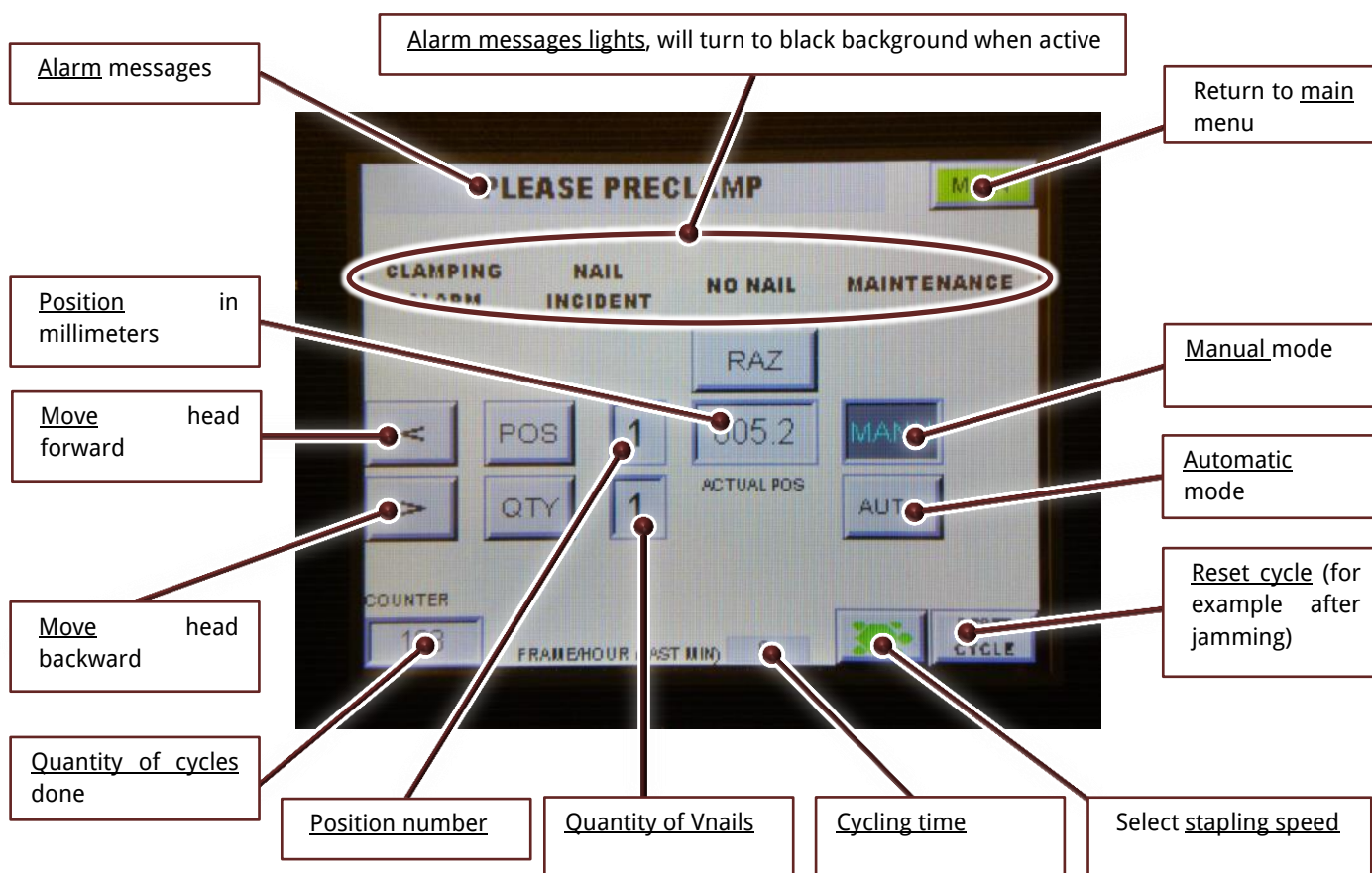


Figure 5-51

5.I SIMPLE SCREEN: REVIEW OF ALL BUTTONS

This screen will display positions one by one.



English

5.J USE OF REGULATORS

On the side of the machine are located two regulators.

When using the machine, if a very soft moulding is joined, it is possible to reduce the pressure of the clamps with the regulator **CLAMP PRESSURE**.

For that particular moulding it will also be possible to reduce the speed of the top clamp, as it could leave a little mark on the moulding. Use the regulator **PLUNGER SPEED** to adjust it.

Thanks to the sensors of the machine, 90% of the mouldings can be covered with this regulators set at max value without having to set them.



Figure 5-52

6 SCREENS AND OPTIONS:

All menus will show a **MAIN** button that will allow returning to the main menu.



Figure 6-1

This menu will come up showing various options.

Simple screen and advanced screen are detailed in chapter I.5 PROGRAMMING THE MACHINE (page 20).

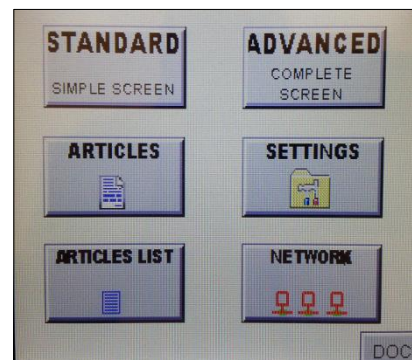


Figure 6-2

6.A ARTICLES SCREEN

This menu will allow to manage the articles in the memory of the machine.

You can program an article here and execute another one in the simple or advanced screen.

The parameters will be entered as in chapter I.5 PROGRAMMING THE MACHINE (page 20).

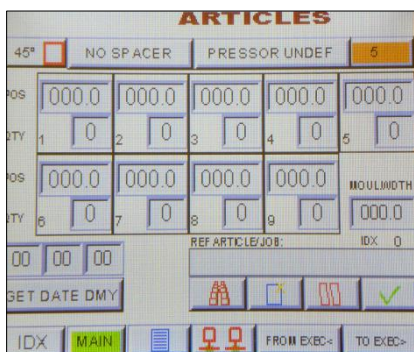


Figure 6-3

Once the positions and options are set you can also add a date.

Touch the 3 boxes for Day, Month, Year setting, you can also use **GET DATE DMY** to set it to the current date.

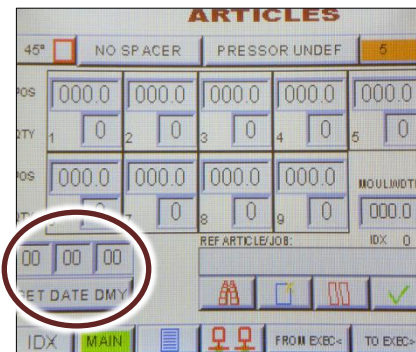


Figure 6-4

To delete an article, enter the reference to be deleted in the field.

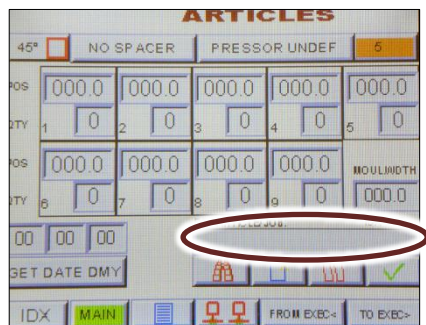


Figure 6-5

Then press the research button to display the parameters of the article.

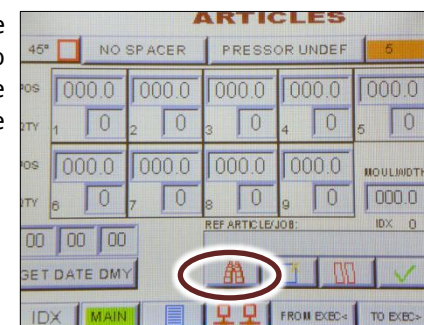


Figure 6-6

Press the delete button to suppress the reference.

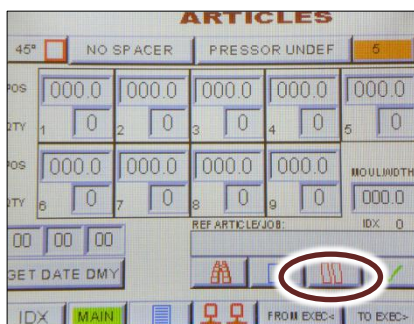


Figure 6-7

Press **DELETE** button to confirm suppression.

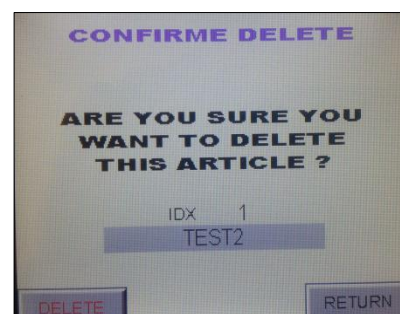


Figure 6-8

6.B SETTINGS SCREEN

In this chapter are detailed the most important parameters that are available in pages of setting section.

Six pages of parameters are available, use the bottom line to display the needed page.

Some parameters are protected by a code, it is recommended not to change any setting without instruction. Contact your Cassese agent for more details if the parameter is not described in this section.

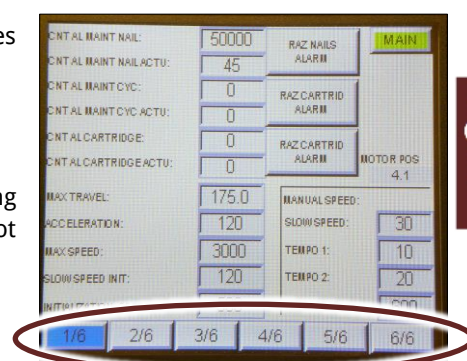


Figure 6-9



Some parameters can affect the safety or functions of the machine, do not attempt to modify any setting without precise instructions from Cassese. Do not communicate codes to untrained people.

6.B.a Page 1: maintenance alarm

This page is useful to reset the maintenance alarm (see chapter I.7.F RESETTING THE MAINTENANCE ALARM page 44).

It is possible to read the quantity of wedges used since last reset. When this number is more than 50000, maintenance alarm is displayed.

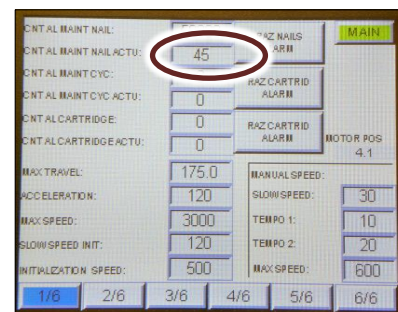


Figure 6-10

6.B.b Page 2: counter configuration

In the execution screen, a counter (see Figure 5-29 and Figure 5-51) can be used.

-if this field is set to 1, the amount of corner will be displayed in the execution screen.

-if this field is set to 4 the amount of frame is displayed.

Set this parameter accordingly.

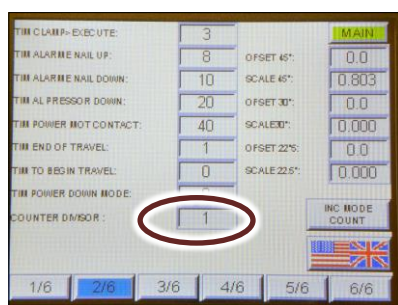


Figure 6-11

This parameter set at **DEC MODE COUNT** will set the counter in decrease mode, counting backwards.

This parameter set at **INC MODE COUNT** will set the counter in increase mode, counting upwards.

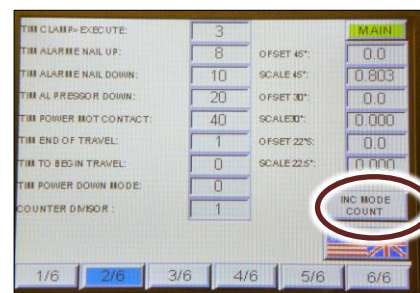


Figure 6-12

6.B.c Page 2: fine tuning of the shooting position

If the machine doesn't shoot in the right position, it is possible to calibrate it.

Applying +1 to **OFFSET 45** will increase the position of all wedges of +1mm.

After touching that button, a code will be requested, enter 9059 at prompt. Once the setting is done, turn off the machine to lock back the parameters.

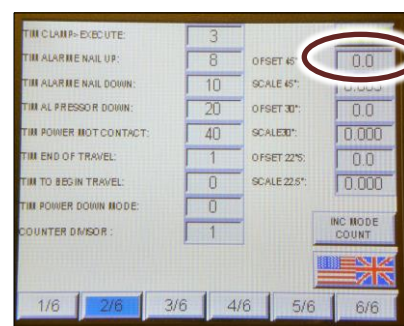


Figure 6-13

6.B.d Page 2: changing the language of the machine

It is possible to change the language from that page, press the flag several times until the right language is displayed.

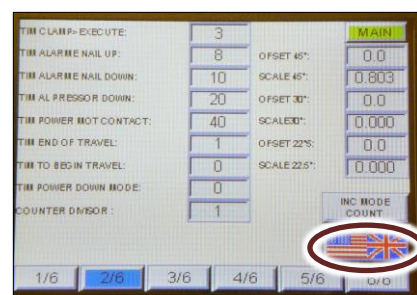


Figure 6-14

6.B.e Page 3: setting date and time

Press this button to set date/time.

The machine will ask for a code, enter the code 9059.

A keyboard will come ON to allow you to enter your parameters.

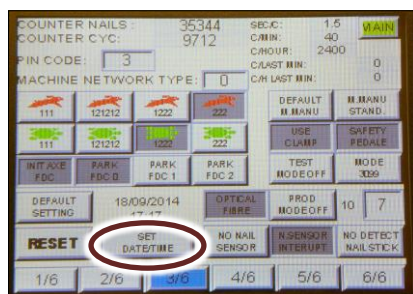


Figure 6-15

Use arrows to select the data to modify, then + or - to change the setting.

Press **SAVE** button before to **QUIT**.

Once the setting is done, turn off the machine to lock back the parameters.

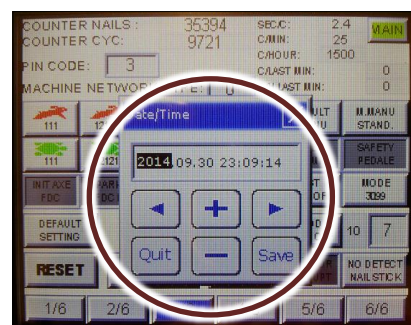


Figure 6-16

6.B.f Page 3: choosing the favorite execution screen

When the machine is started up, the welcome screen will appear. Changing that option will make the machine going in simple screen immediately (select **MODE 486**) or in advanced screen immediately (select **MODE 3099**) when you will touch the welcome screen.

The machine will ask for a code, enter the code 9059. Once the setting is done, turn off the machine to lock back the parameters.

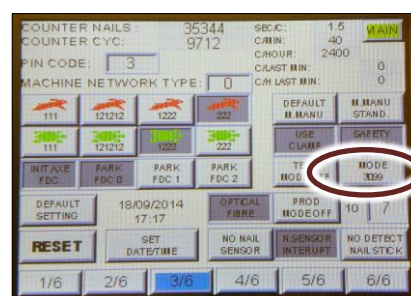


Figure 6-17

6.B.g Page 3: overriding wedge sensor:

In case the wedge sensor is causing problems, it is possible to deactivate it (machine will not detect anymore the end of the cartridge).

Change **OPTICAL FIBRE** to **NO NAIL SENSOR**.

You will be asked for the code 9059.

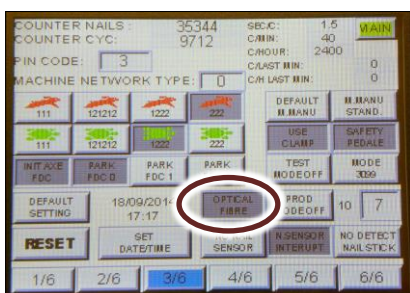


Figure 6-18

Make sure this parameter is also set to **NO NAIL SENSOR**.

Once the setting is done, turn off the machine to lock back the parameters.



Figure 6-19

6.B.h Page 3: reading the statistics

The machine is measuring permanently the time spent to make a corner to display the following statistics:

SEC/C: measures how long it took to make the last cycle (in seconds).

C/MIN: tells how many cycles of the last job could be done in a minute.

C/HOUR: tells how many cycles of the last job could be done in a hour.

C/LAST MIN: measure how many cycles where done in the last minute.

C/H LAST MIN: measure how many cycles where done in the last hour.

You can also have access to the following:

COUNTER NAILS: amount of nails shoot by the machine since it was build.

COUNTER CYC: amount of corners done by the machine since it was build.



Figure 6-20

6.B.i Page 3: configuring the manual mode

The manual mode consist in pressing the pedal to get the clamp activation and then press once the stapling button to launch the complete stapling sequence of the corner.

It is possible to set the manual mode to a more detailed sequence. The operator will then have to use stapling button at each position of wedge, this allowing a better quality control for special jobs.

You will be asked for the code 9059 to be able to set that parameter. Once the setting is done, turn off the machine to lock back the parameters.

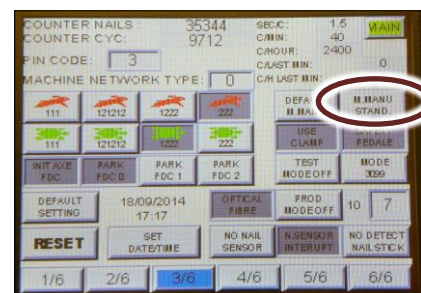


Figure 6-21

6.B.j Page 4: Reading input/outputs

This page his helpful to check if a component of the machine is working.

Left column is dedicated to input signals, yellow background will come on when activated.

Right column is dedicated to outputs, red background will come on when activated.

This page is real time visualization, it is possible to achieve it while launching a stapling.

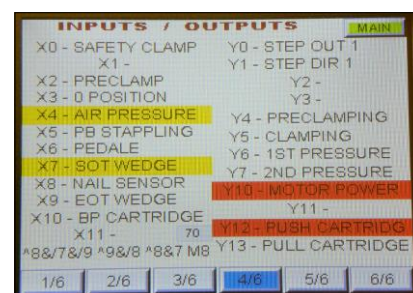


Figure 6-22

6.B.k Page 5: database management

The database of the machine can store up to 2990 files. This page is dedicated to its management. Any action in this page, due to the volumes of datas, will take up to 15 minutes during which the machine can 't be used. It is possible to reduce the database sizing to reduce this time. If you know you don't have more then 500 files for example, then enter 500 in the field **DATABASE SIZE**, this will reduce the necessary time for treatment.

Once you are done with the database management, do not forget to put it back to 2990 or the machine will not be able to store the 2990 files and the "full memory" message will be displayed.

You will be asked for the code 0721 to be able to set that parameter. Once the setting is done, turn off the machine to lock back the parameters.

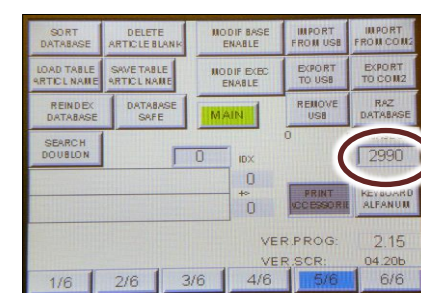


Figure 6-23

Classifying the references:

The machine is storing a new file in the first free location of its memory. It means you might not have a A to Z classification, depending of the order you have been creating/deleting your files.

To classify your files in a A to Z order, press the **SORT DATABASE** button. Refer to procedure of Figure 6-23 prior to launch this procedure in order to reduce the treatment time.

You will be asked for a code, enter 0271 to get access to that function. Once the setting is done, turn off the machine to lock back the parameters.

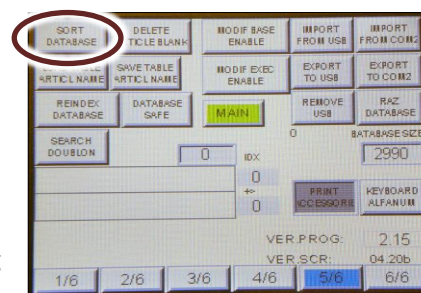


Figure 6-24

Deleting blank articles:

When deleting a file the machine will keep a blank allocation in the list of the articles, if you wish to have a continuous list and remove these blank articles, use that **DELETE ARTICLE BLANK** button. Refer to procedure of Figure 6-23 prior to launch this procedure in order to reduce the treatment time.

You will be asked for a code, enter 0271 to get access to that function. Once the setting is done, turn off the machine to lock back the parameters.

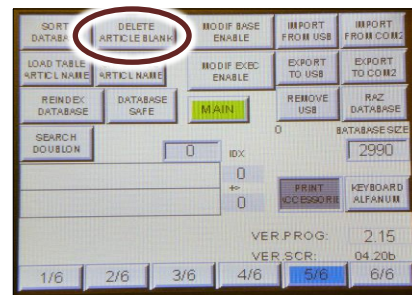


Figure 6-25

Protecting the database:

You can prevent operators from modifying the recorded files, press **MODIF BASE ENABLE** to allow or not this modification.

At this time it is still possible to program some new job, without storing them, if you want operators to use only what is in the memory, press button **MODIF EXEC ENABLE** to allow them or not to do that.

You will be asked for a code, enter 0271 to get access to that function. Once the setting is done, turn off the machine to lock back the parameters.

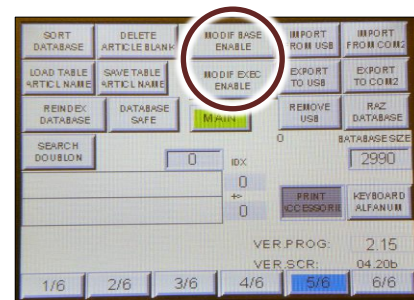


Figure 6-26

Exporting database:

USB key fat32 1Giga mini
Allen key N.3

It is possible to export your files to a USB key so you can save your database or transfer them to another machine. Prior to do this, switch off the machine and unplug it. Remove these 2 back screws.



Figure 6-27

Remove these 2 front screws



Figure 6-28

Open the top cover and plug your usb key at the back of the screen. Put back the screen in normal position and plug back the machine.

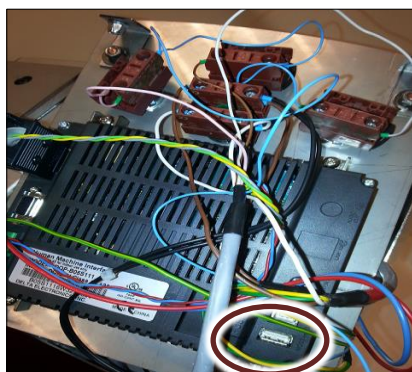


Figure 6-29

Go in setting screen page 5 and press button **EXPORT TO USB**. Wait for process to be finished. Press **REMOVE USB** before to unplug your key. Then put back in place top cover and screws.

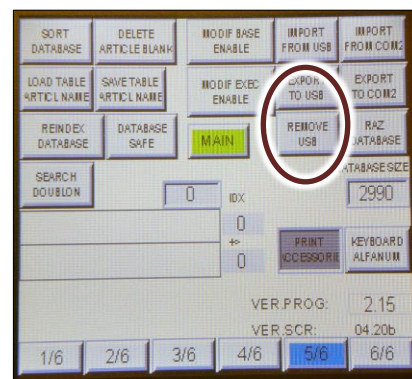


Figure 6-30

Importing database:

USB key fat32
Allen key N.3

Repeat procedure Figure 6-27, Figure 6-28, Figure 6-29. Then select setting screen page 5 and press button **IMPORT TO USB**. Wait for process to be finished.

Press **REMOVE USB** before to unplug your key.

Then put back in place top cover and screws.

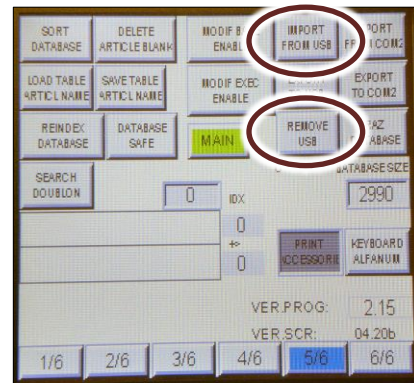


Figure 6-31



Importing database in a target machine will erase all files that were previously in the memory of that target machine and replace them by the source machine's database.

English

Deleting the complete article file:

Press the **RAZ DATABASE** to delete all the files in the memory. Be careful, there is no way to recover the deleted files after doing this!

You will be asked for a code, enter 0271 to get access to that function.

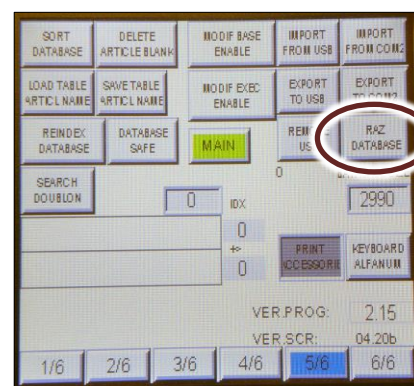


Figure 6-32

Accessories screen:

When using the machine after recalling a memorized article the machine will display on a dedicated screen the various accessories to be used.

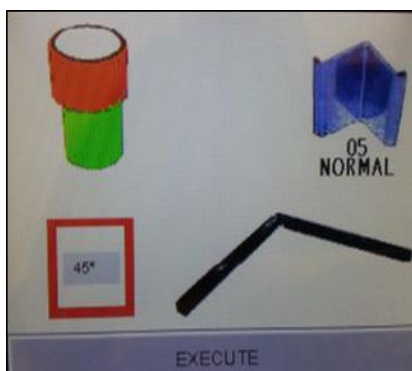


Figure 6-33

The button **PRINT ACCESSORIES** will be used to activate or not that accessories screen. Removing that screen will save time but operator could use bad wedges or do mistakes selecting their accessories.

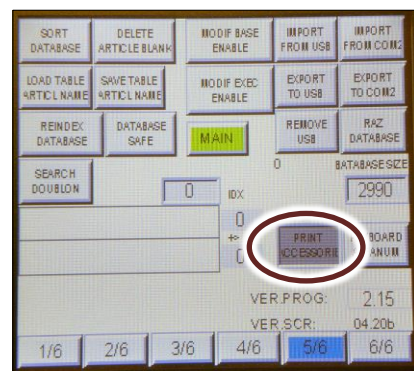


Figure 6-34

Keyboard configuration:

When recording an article file, a keyboard can be used to enter the reference. If you don't need alphanumeric references it is possible to get only a simple numeric keyboard. Press **KEYBOARD ALFANUM** button to configure it.



Figure 6-35

When **KEYBOARD NUM** is selected only that simple keyboard will be displayed for referring an article.



Figure 6-36

6.B.I Page 6: barcode management:

If you are using a barcode reader, you can configure the type of barcodes that the machine will accept. It can accept barcodes from older machine such as cs486 or cs3099 and of course barcodes that were created for a cs4008. This option is useful if you had these machines and don't want to modify your edition software. For example selecting the BC 486 option, will allow using the old barcodes of a CS486ultra, but the machine will not show the accessories to be used (such as spacer bars, type of top clamp) as the CS486 didn't have that feature.

Touch the button BC4008 and set it to the required value.

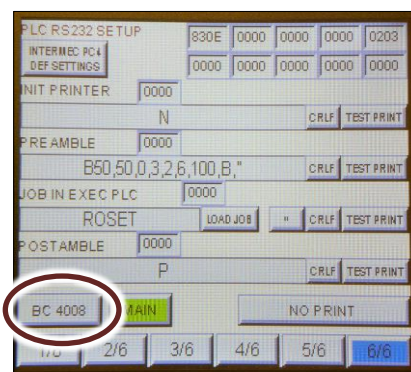


Figure 6-37

English



All MACH 4 CART are ready to be plugged to a barcode reader, but it is strongly recommended to buy the scanner from Cassese to avoid compatibility issues. The barcode plug is a serial port located under the control panel.

6.C ARTICLE LIST SCREEN:

From the main menu, select **ARTICLES LIST**.

This menu will be used to display the article list in the memory of the machine.

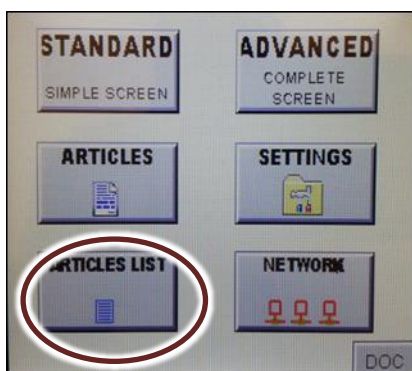


Figure 6-38

The left column is showing the first 10 references in the memory of the machine. Press **-10** or **-100** to scroll down of **+10** or **+100** references of the list.

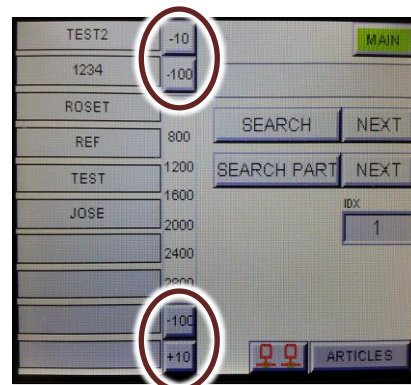


Figure 6-39

When scrolling up or down a grey background will show your current position in the memory list.

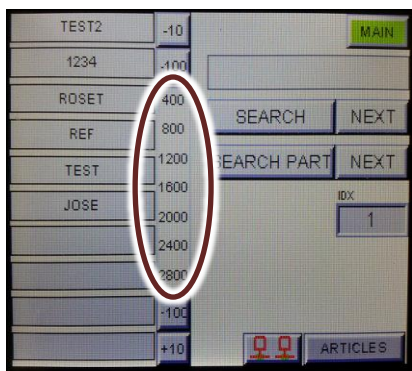


Figure 6-40

If you need to achieve a particular reference, enter a value in this field and press **SEARCH** to achieve it. Press **NEXT** button to look for the next same reference in the memory.

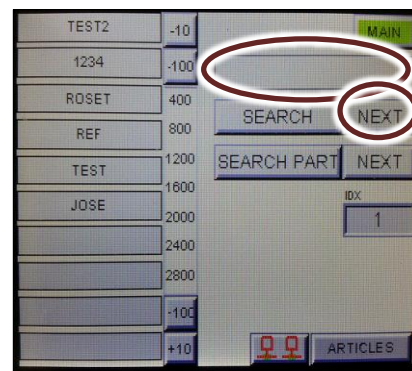


Figure 6-41

If you only know the beginning of a reference, enter a value in this field and press **SEARCH PART** to achieve the first reference beginning by the value you entered. Press **NEXT** button to look for the next one.

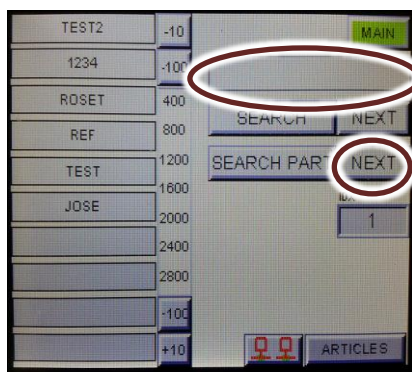


Figure 6-42

This file shows the position in the memory.

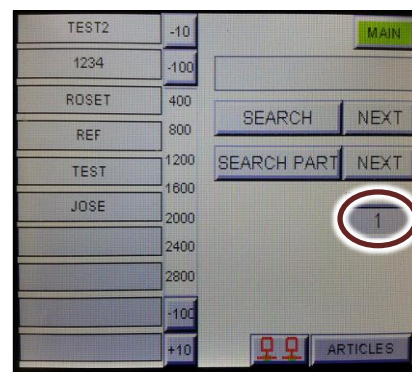


Figure 6-43

English

6.D NETWORK MENU

The MACH 4 CART integrates some network capabilities. The machine is designed to have the possibility of receiving a list of jobs to be done through a network. The operator can then select the job he wants to do in this list. The parameters for the execution will then be sent through the network so the machine can be used without having to program it, and even without having to scan anything. This will avoid errors and will save time. It means also the operators don't have to pick up any paperwork, they remain at their machine which will display them the list of jobs to be performed. It becomes also possible to follow the production status in live time and analyse the production time for each product and have a better view of the exact cost of each frame.

At the back of the screen of the machine is a serial sub DB9 connector. This serial communication port will be used to communicate with the machine. All machines will be connected to the serial network. Contact our technical service for more details and protocol of communication if you wish to use that network possibility.

From the main menu, select **NETWORK**.



Figure 6-44

The left column is showing the first 10 more important jobs to be done. This list comes from the network. The top line is in top priority. Selecting a reference from that left column will load the article parameters from the network.

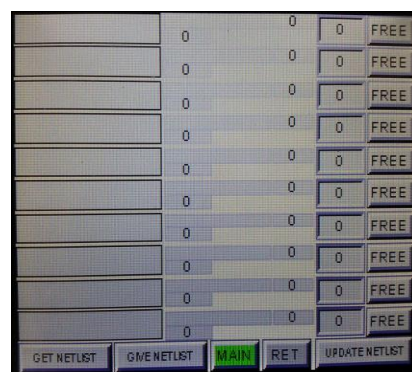


Figure 6-45

The execution of the job will be as normal use of the machine, but at the end of the job, the operator will come back to that screen to mention how many pieces were effectively done.

The Network menu can be accessed through different screens by pressing this button :



7 MAINTENANCE

7.A SAFETY INSTRUCTIONS



The MACH 4 CART is using two types of power sources: electric and pneumatic. It is essential for your safety to make sure that both of them are disconnected prior to make any maintenance. Please refer to instructions below prior to perform any maintenance.

Unplug the machine from the electrical supply



Figure 7-1

Rotate red button in EXH position.
Unplug the machine from pneumatic source.
Install a locker to ensure nobody will turn back on the machine while you will be performing the maintenance.



Figure 7-2



If using compressed air to clean some parts, wear safety glasses. It is even recommended to use a vacuum to clean the machine rather than compressed air that will spray dust everywhere.
All maintenance and control operations must be carried out by skilled maintenance staff.

English

7.B MAINTENANCE PLAN

7.B.a Daily maintenance:

It is recommended once a day to clean the table surface with a clean cloth and make sure there is no debris in the distributor head. If some glue is remaining in the distribution block, then perform procedure 7.C REMOVING THE DISTRIBUTOR HEAD (page 42) and 7.D LUBRICATING THE DISTRIBUTOR HEAD (page 43). It is important to avoid glue from drying in the distribution head as it could prevent the cartridge from going in the distribution block correctly.

7.B.b Regular maintenance:

Every 50 000 inserted wedges, the machine will ask for a maintenance a warning screen will come up asking you to lubricate the distribution head. Refer to following chapter to perform this maintenance:

- 7.A SAFETY INSTRUCTIONS (page: 41)
- 7.C REMOVING THE DISTRIBUTOR HEAD (page 42)
- 7.D LUBRICATING THE DISTRIBUTOR HEAD (page 43)
- 7.F RESETTING THE MAINTENANCE ALARM (page 44)

7.B.c Every 6 months:

Every 6 months a maintenance should be performed to ensure proper function of the machine, perform the following procedure to do it:

- 7.A SAFETY INSTRUCTIONS (page 41)
- 7.C REMOVING THE DISTRIBUTOR HEAD (page 42)
- 7.D LUBRICATING THE DISTRIBUTOR HEAD (page 43)
- 7.F RESETTING THE MAINTENANCE ALARM (page 44)
- 7.G REMOVING THE SIDE PANEL (page 44)
- 7.H LUBRICATING THE HORIZONTAL COLUMNS (page 45)
- 7.I TESTING THE SAFETIES OF THE MACHINE (page 45)

7.C REMOVING THE DISTRIBUTOR HEAD

Periodically, remove the distributor head to clean and lubricate it. First, remove the strip of wedges. To do so, follow this procedure :



Allen key N.2 & N.5

Rotate the loading button in the **LOAD** position.

The wedge pusher will move back to allow you removing the cartridge.



Figure 7-4

Remove the cartridge.

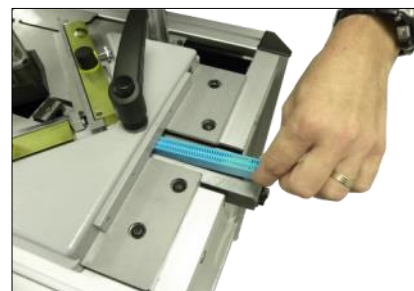


Figure 7-3

With the 2.5mm Allen Key, unscrew the locking screw half a turn.

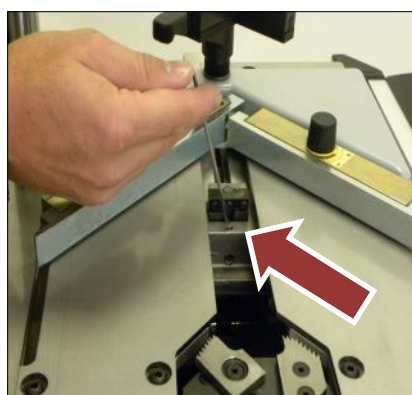


Figure 7-5

Pull out the distributor head of the machine.

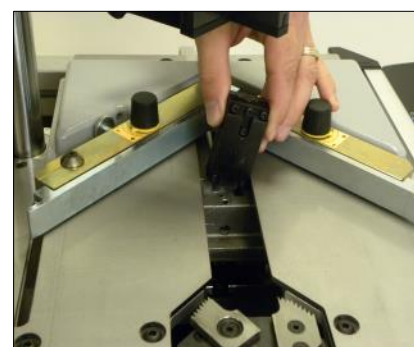


Figure 7-6

7.D LUBRICATING THE DISTRIBUTOR HEAD



Flat span N.13 & N.17
Allen key N.5

Grease tube, Cassese reference Z1896
Lubricant spray, for example WD40.

Remove all the screws of the distributor head.



Figure 7-7

Separate the distributor plates and clean them using a clean cloth and lubricant spray.

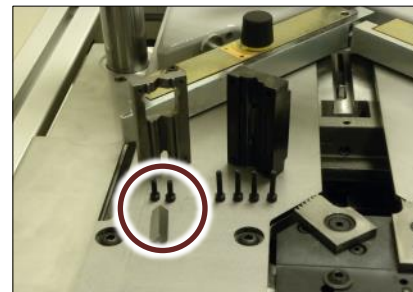


Figure 7-8

Insert the equivalent of a nut of grease in the bottom of the distributor head.



Figure 7-9

English

7.E UNJAMMING THE MACHINE



Wedge removal tool Z535

Sometime a wedge or a driver blade can stuck in top position.



Figure 7-10

Use the tool to try to push down the wedge in the distribution head. The tool needs to be inserted only of about 5mm in the distribution head, then remove the tool and try to remove the cartridge.

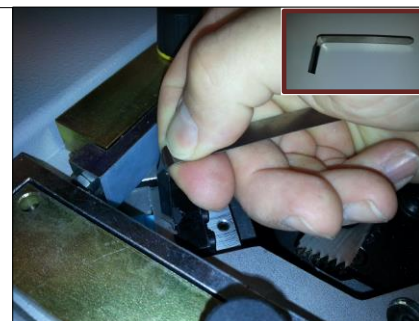


Figure 7-11

If you can't push down the protruding Wedge/driver blade, then put your hands on top of the vertical column and give a shock down. An audible "clack" sound should confirm the hammer is unlocked.

Try to apply procedure I.7.C REMOVING THE DISTRIBUTOR HEAD (page 42) to remove the distributor and be able to remove the jammed hammer. If the distributor head can't be removed, apply again a shock down and try to remove the distributor.



Figure 7-12

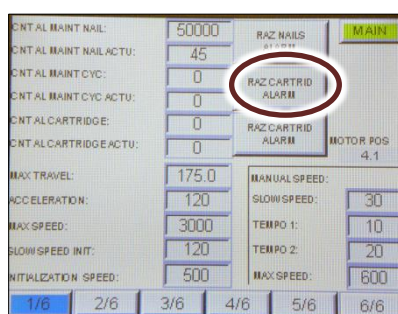


Never push with your finger on a protruding wedge, they are very sharpened!!!

7.F RESETTING THE MAINTENANCE ALARM

From the execution menu, press **MAIN** button to return the main menu and select **SETTING** button.

Press the **RAZ NAILS ALARM** button, a keyboard asking for a code will come up.



Enter the code 5000 to reset the alarm message.



English

Figure 7-14

Figure 7-13

7.G REMOVING THE SIDE PANEL



Allen Key N.3

In order to have an access to mechanical parts, it is imperative to remove the side panel of the opposite side to the screen.

With the 3mm Allen Key, unscrew the 4 locking screws.

Then remove the side panel.



Figure 7-15

7.H LUBRICATING THE HORIZONTAL COLUMNS



Allen Key N.3
Clean cloth with lubricant spray such as WD40
Engine car oil

Refer to chapter I.7.A SAFETY INSTRUCTIONS (page 41) for safety instructions.

Remove the side panel as explained in the chapter I.7.G REMOVING THE SIDE PANEL (page 44).

Clean with clean cloth the 2 horizontal columns and apply some engine car oil on them.

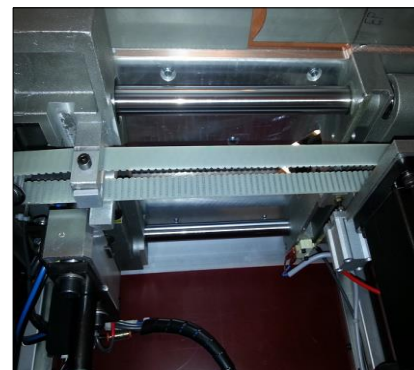


Figure 7-16

7.I TESTING THE SAFETIES OF THE MACHINE

Make sure the machine will switch ON/OFF when using the red button.

This button should remain in pushed position (OFF) until you rotate it to release it. If not, contact your local agent to replace the button assembly.



Figure 7-17

Go in parameters screen.

Select the page N.4.

Do not put your hands on the tables, make sure there is nothing on them.

Press the pedal and check that the yellow background comes on under the line **X6- PEDALE**, the background should come off when the pedal is released.

If not, contact your local agent to replace the pedal assembly.

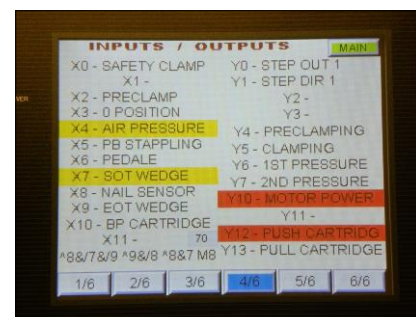


Figure 7-18

Switch ON the machine and plug the air in. Go in the execution screen and switch back off the air.

An alarm message should come on indicating pressure is not correct, if not contact your local agent for diagnostic.



Figure 7-19

Set the machine in manual mode, remove mouldings from the table and try to press the pedal. The machine shouldn't try to shoot with no moulding and the safety message should be displayed. If it tries to staple, then contact your local agent for repair.



Figure 7-20



Make sure that machine is complete and that no part was removed, all side panels must be closed and all screws in place. In case of missing item, use exploded views to order the missing part. Missing side panel will expose moving part which is dangerous for operators.

7.J TROUBLE SHOOTING

if your machine is not working properly, please refer to FAQ bellow, if the solution of your trouble is not in this section, please contact your local distributor or contact us on our web site: www.cassese.com.

Nothing lights up, the screen is off even when the emergency button is released:

> Check, for example by connecting another appliance, that the electrical outlet on which is plugged the machine is not defective.

The machine displays the message «alarm air pressure» and will not staple.

> Adjust the air pressure of the compressor or the machine, see chapter 2.B CONNECTING TO THE AIR SOURCE (page 12).

The machine displays the message «nails maintenance».

> Refer to the chapter 7.B MAINTENANCE PLAN (page 41).

The machine displays the message «pedal and pre-clamp».

> The pre-clamping button is still in the «ON» position during an attempt at joining by pressing the pedal. Turn it to «OFF» before pushing the pedal.

When pushing the pedal, the machine blocks the mouldings with the clamps, but then releases them and does not shoot the wedge. The message «safety clamping» is displayed.

- > The table has moved back (handle not tightened enough) and proper clamping of the mouldings is not possible. Repeat the pre-clamping procedure, see chapter I.4.A ADJUSTMENT OF THE SLIDING TABLE (page 15).
- > The pre-clamping procedure was not performed correctly. Try again, following the instructions in chapter I.4.A ADJUSTMENT OF THE SLIDING TABLE (page 15).

The machine appears to be inserting the wedges normally, but the wedges are not completely inserted.

- > The hammer is broken. Perform the procedure described in chapter 7.C REMOVING THE DISTRIBUTOR HEAD (page 42).
- > The moulding is too low or too narrow. Therefore, the vertical clamp cannot block it correctly against the stops. Use the «set of spacer bars» to join the moulding (see chapter 4.C SPECIFIC USE OF THE SPACER BARS page 16).
- > Air pressure is too low. Adjust the air pressure of the compressor or the machine, see chapter 2.B CONNECTING TO THE AIR SOURCE (page 12).
- > The moulding is not properly clamped to the table during the stapling process. Check the stapling position for stability of the vertical clamp and that the moulding is properly braced against the table. If you are using the machine near a table supporting the frame, make sure the mouldings remain level. If this is not the case, adjust the furniture or the machine so they are the same height (the machine has adjustable feet).

> The pedal was released too quickly. Try stapling again, keeping the pedal down until the cycle is completely finished.

The machine blocks, with the vertical presser against the moulding, then releases the pressure and displays the messages «alarm nail up».

> Air pressure is too low. Adjust the air pressure of the compressor or the machine. DO NOT exceed 8 bars, see chapter 2.B CONNECTING TO THE AIR SOURCE (page 12).

> The wood is too hard. You can increase pressure, but DO NOT exceed 8 bars. Use «hardwood» wedges.

> Try to use lower size of wedges or decrease the number of wedges at the blocking position (if stacking).

> The hammer is twisted or blocked. Perform the procedure described in chapter 7.C REMOVING THE DISTRIBUTOR HEAD (page 42).

> The distance between the top clamp and moulding is too high. Adjust the height of the presser support with the pin. It should be less than 5 centimetres.

> The downward movement of the presser is too slow. Use the speed regulator located on the side of the machine to increase it.

The machine blocks, with the vertical presser against the moulding, then releases the pressure and displays the message «alarm nail down».

> The pedal was released too quickly. Try stapling again, keeping the pedal down until the cycle is completely finished.

The machine blocks and displays the message «start of travel nail».

>The sensor that informs the machine that the hammer is in the down position sends information that the hammer has not returned down. Perform the procedure in chapter 7.C REMOVING THE DISTRIBUTOR HEAD (page 42).

The wedge breaks in the wood.

>The wood is too hard. Use special «hardwood» wedges.

>The backs are stained.

The distributor is full of grease.

>Perform the procedure described in chapter 7.C REMOVING THE DISTRIBUTOR HEAD (page 42) and remove any excess grease. Do some stapling in scrap mouldings to purge any excess. Then wipe off the top of the distribution head.

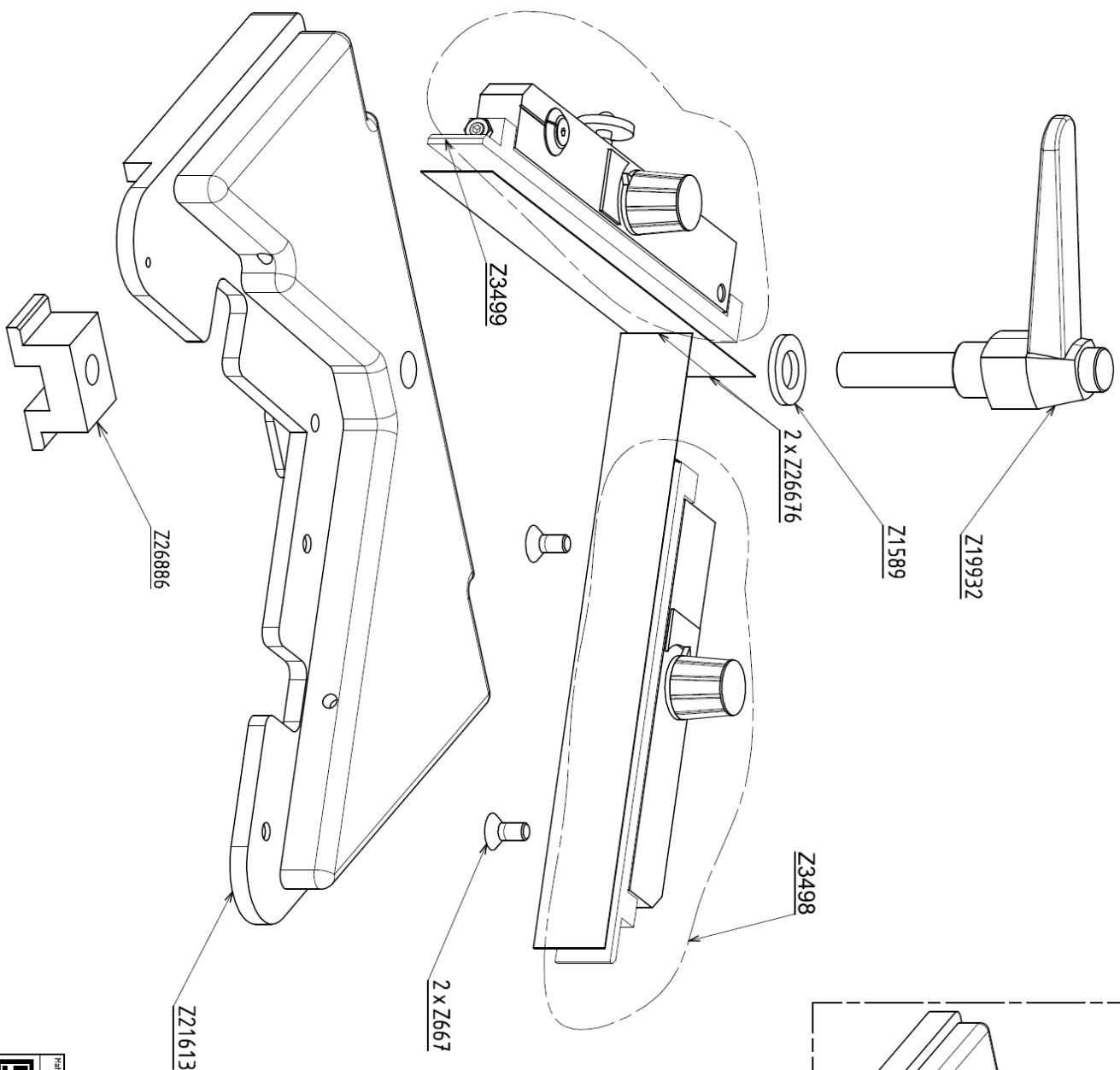
Handling the mouldings is difficult.


The horizontal clamps are too tight against the mouldings. Repeat the pre-clamping procedure described in chapter I.4.A ADJUSTMENT OF THE SLIDING TABLE (page 15).

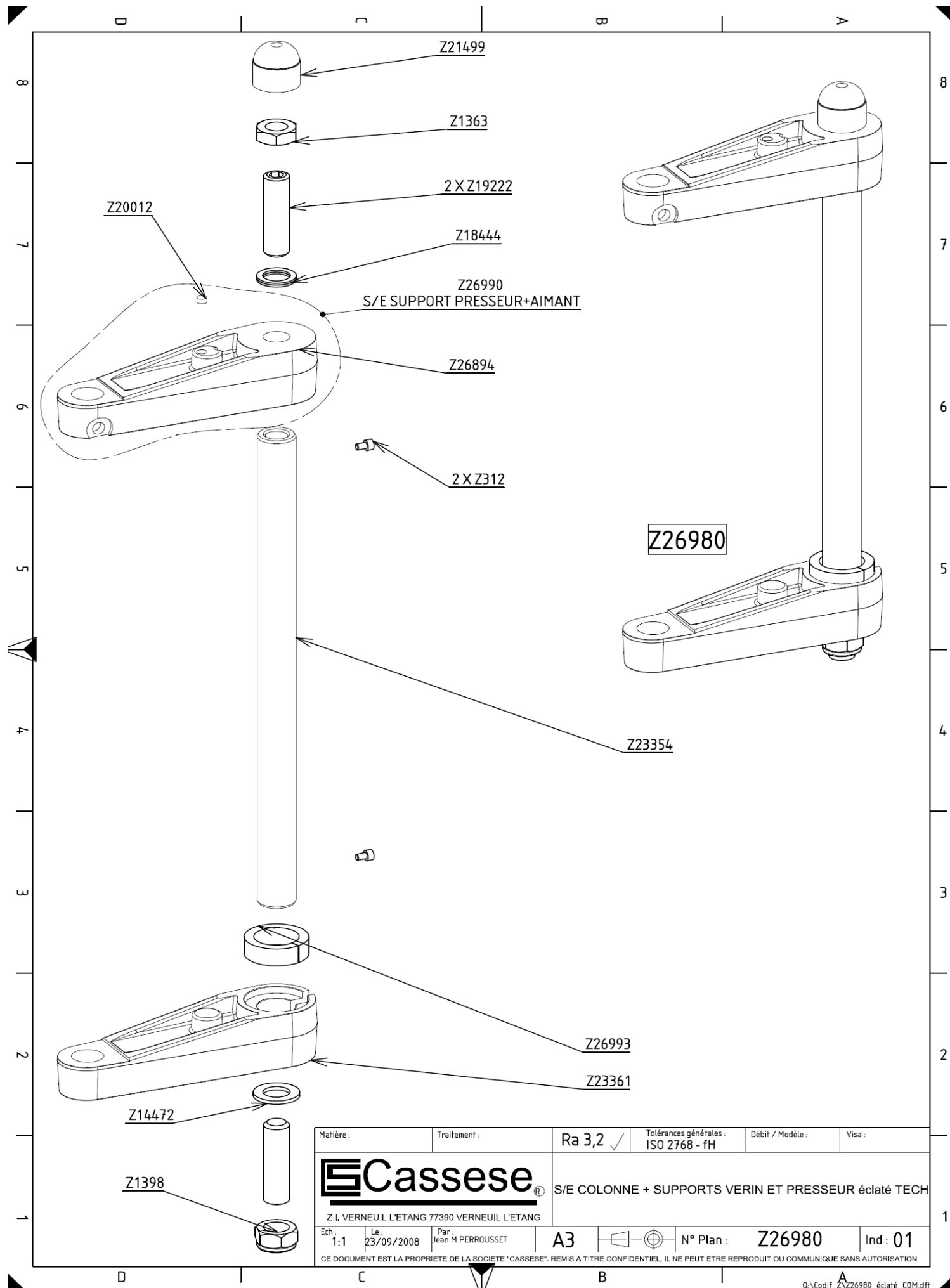
The corners are crooked.

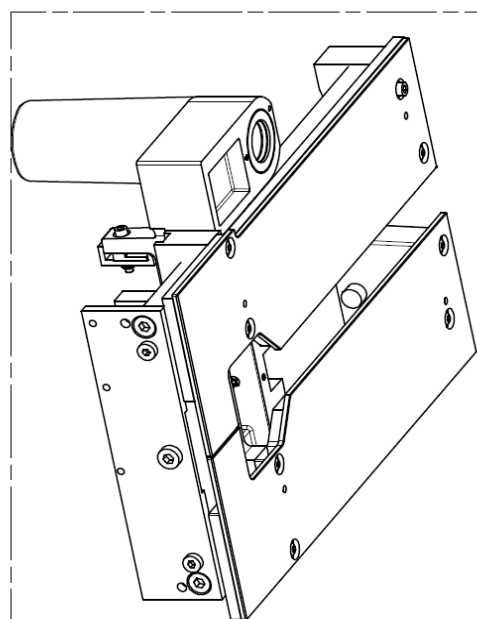
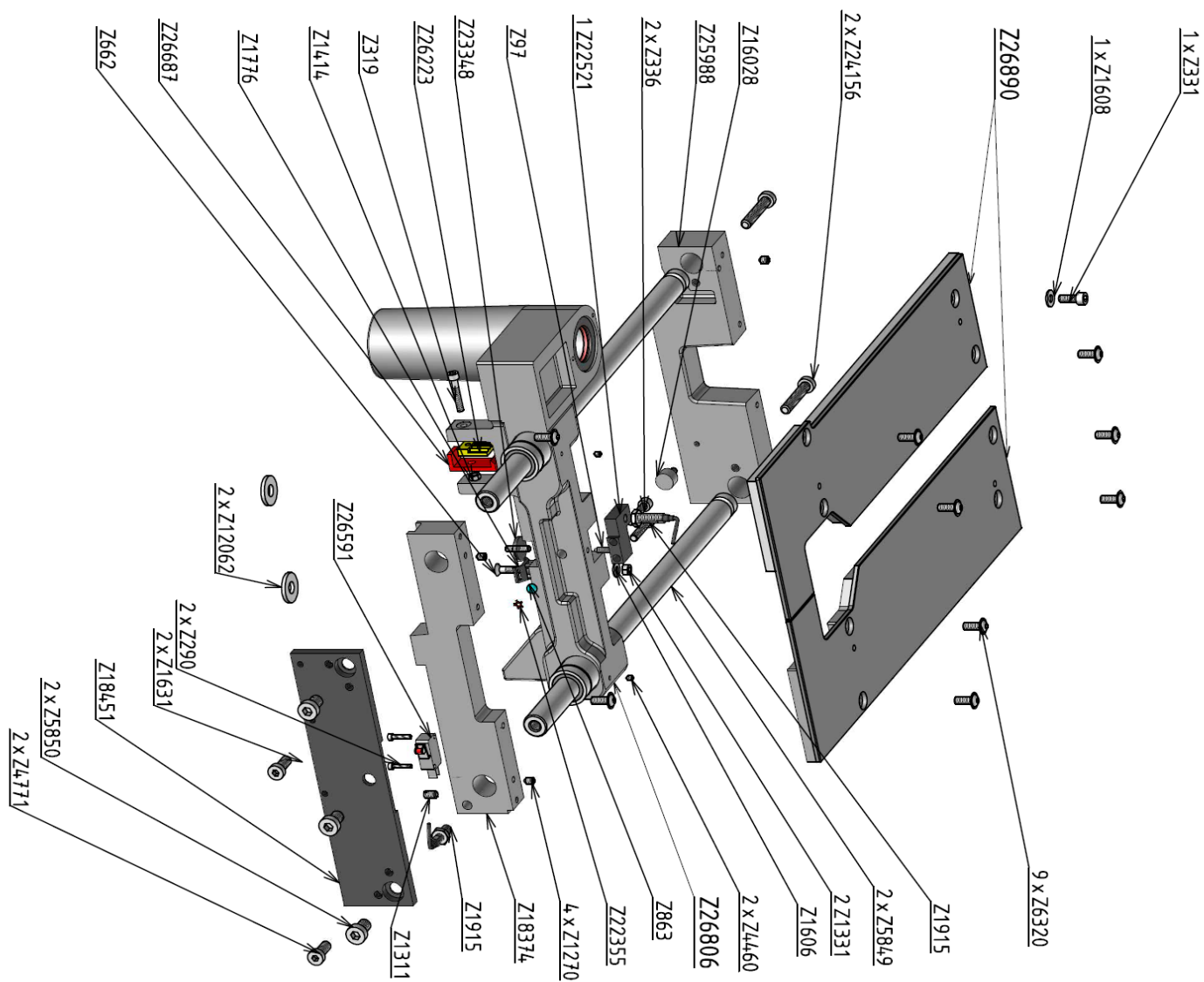
>Make sure to place the first moulding against stop as Figure 5-1.




>Make sure that clamping pressure is sufficient. Use the «clamp pressure» regulator on side of the machine to adjust it see chapter 5.J USE OF REGULATOR (page 30).

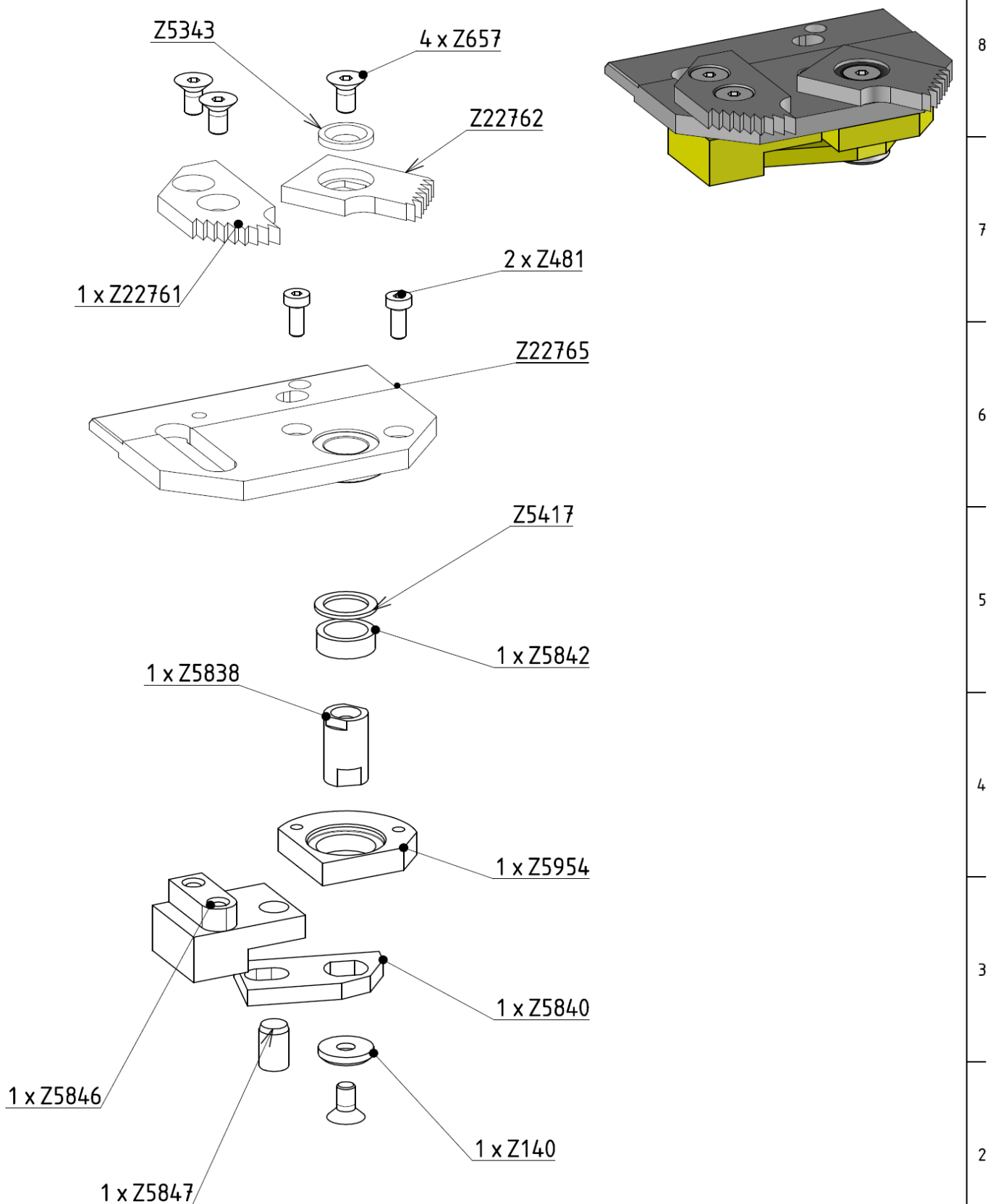


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Z1. VERNEUIL LETING 7730 VERNEUIL LETING					
Ech. 1:1		27/11/2007		N° Plan : Z26891	
Fol. 01		N° Rev. 01		Ind : 01	
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Tolérances dimensionnelles :		ISO 2768 - FH		Débit / Modèle :	
Visa					





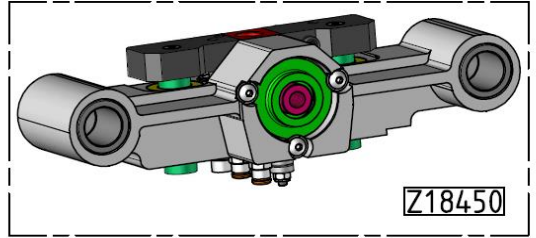
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		Ra 3,2 ✓		
				
ENSEMBLE MECANIQUE COMMUNE CART				
Z1 VERREUIL LETANG 77390 VERREUIL LETANG				
63 0,000 Ls 26/11/2007 Fait MAGNAT CHENOUX	 A2	 N° Part :	Z26725	Ind



Matière :	Traitement :	Ra 3,2 ✓	Tolérances générales : ISO 2768 - fH	Débit / Modèle :	Visa :
Cassese Z.I. VERNEUIL L'ETANG 77390 VERNEUIL L'ETANG			S/E GRIFES ASSEMBLEUSE UNI		
Ech : 1:1	Le : 26/11/2007	Par : Renaud CHEYROU	A3	N° Plan : Z22763	Ind : 01
CE DOCUMENT EST LA PROPRIETE DE LA SOCIETE "CASSESE". REMIS A TITRE CONFIDENTIEL, IL NE PEUT ETRE REPRODUIT OU COMMUNIQUE SANS AUTORISATION					

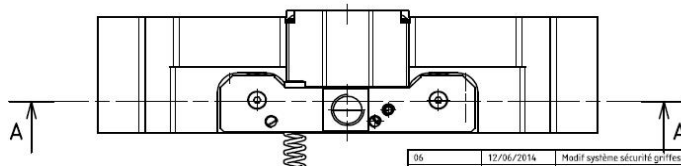
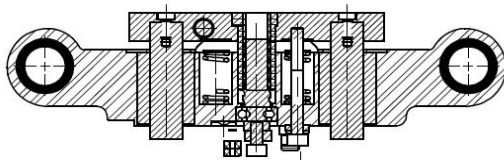
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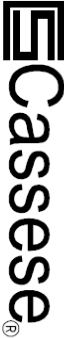
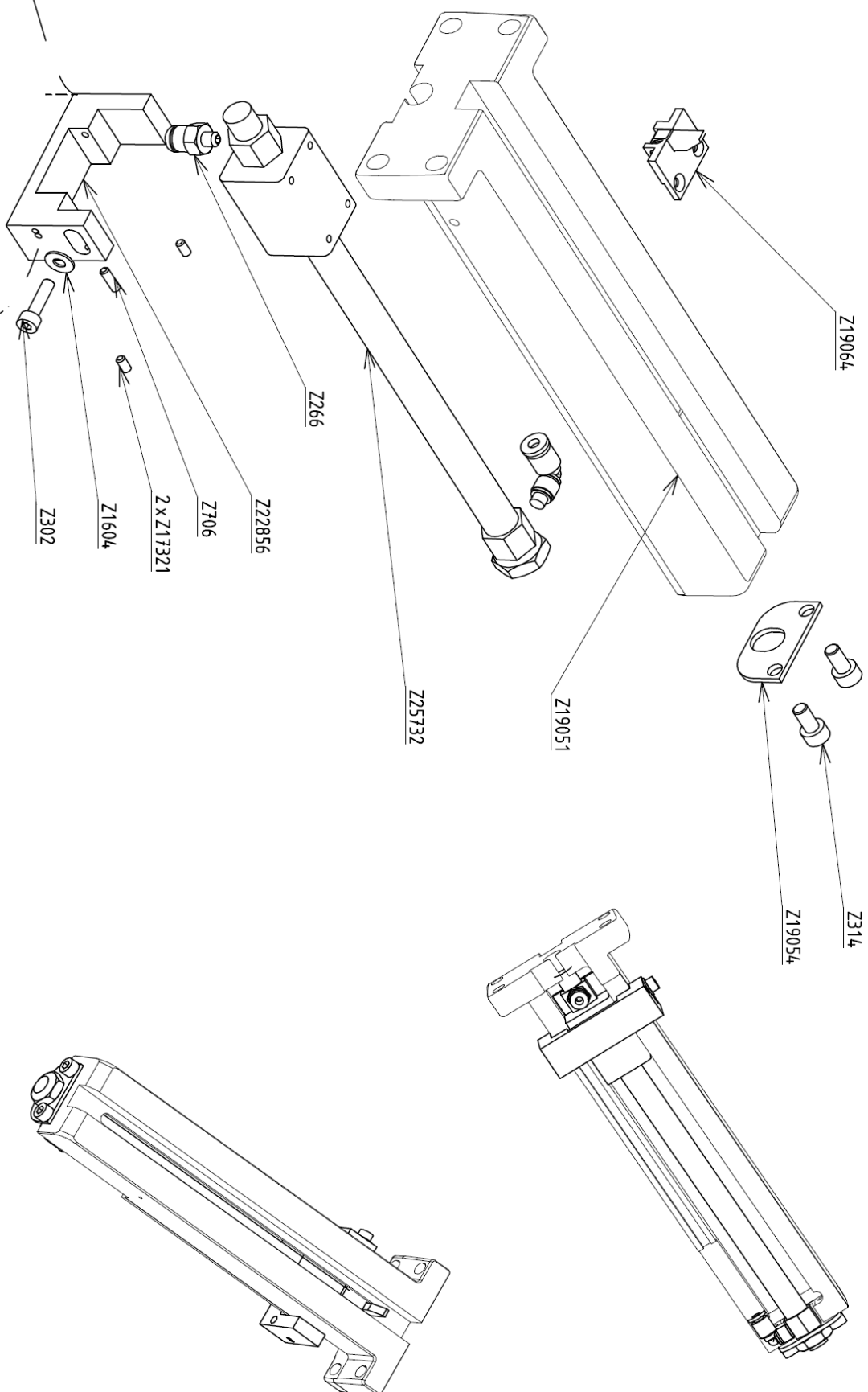
A - A





INDICE	DATE	LIBELLÉ	AUTRIB
06	12/06/2014	Modif système sécurité griffes	Jean M PERROUSSET
05	13/11/2012	Remplace vis Z558 par Z2511+Z1409	Jean M PERROUSSET
04	04/11/2011	inoxidation acro et vis	Jean M PERROUSSET
02	10/02/2010	2 x 1/8 dev. M5 et Lamage vis débouché	Jean M PERROUSSET

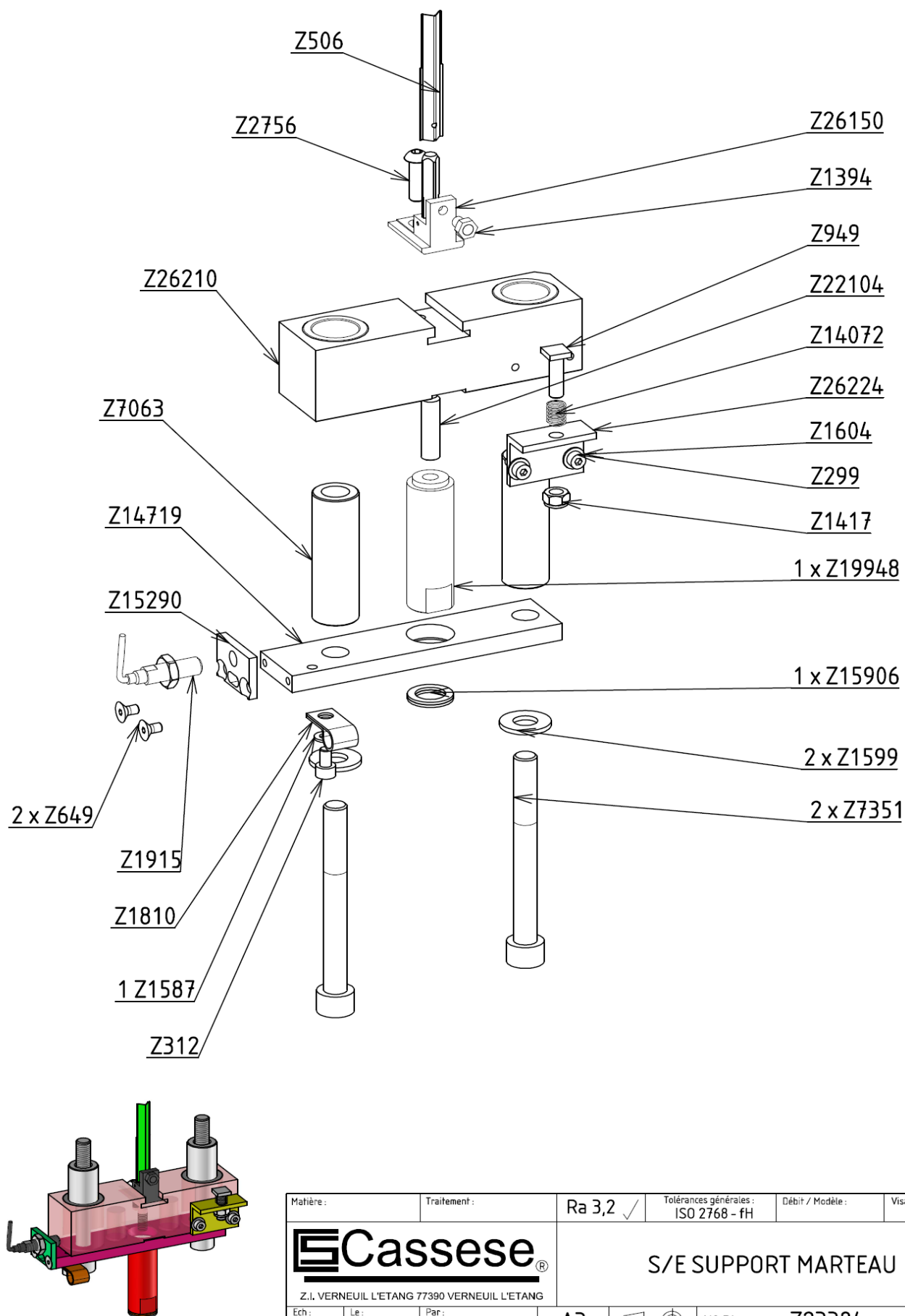
Partie:	Traitement:	Ra 3,2 ✓	Tolérances géométriques: ISO 2158 - FH	Dess / Modèle:	Vis
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N° Plan: Z18450 Ind 06					



Z23392 S/E FIBRES OPTIQUES



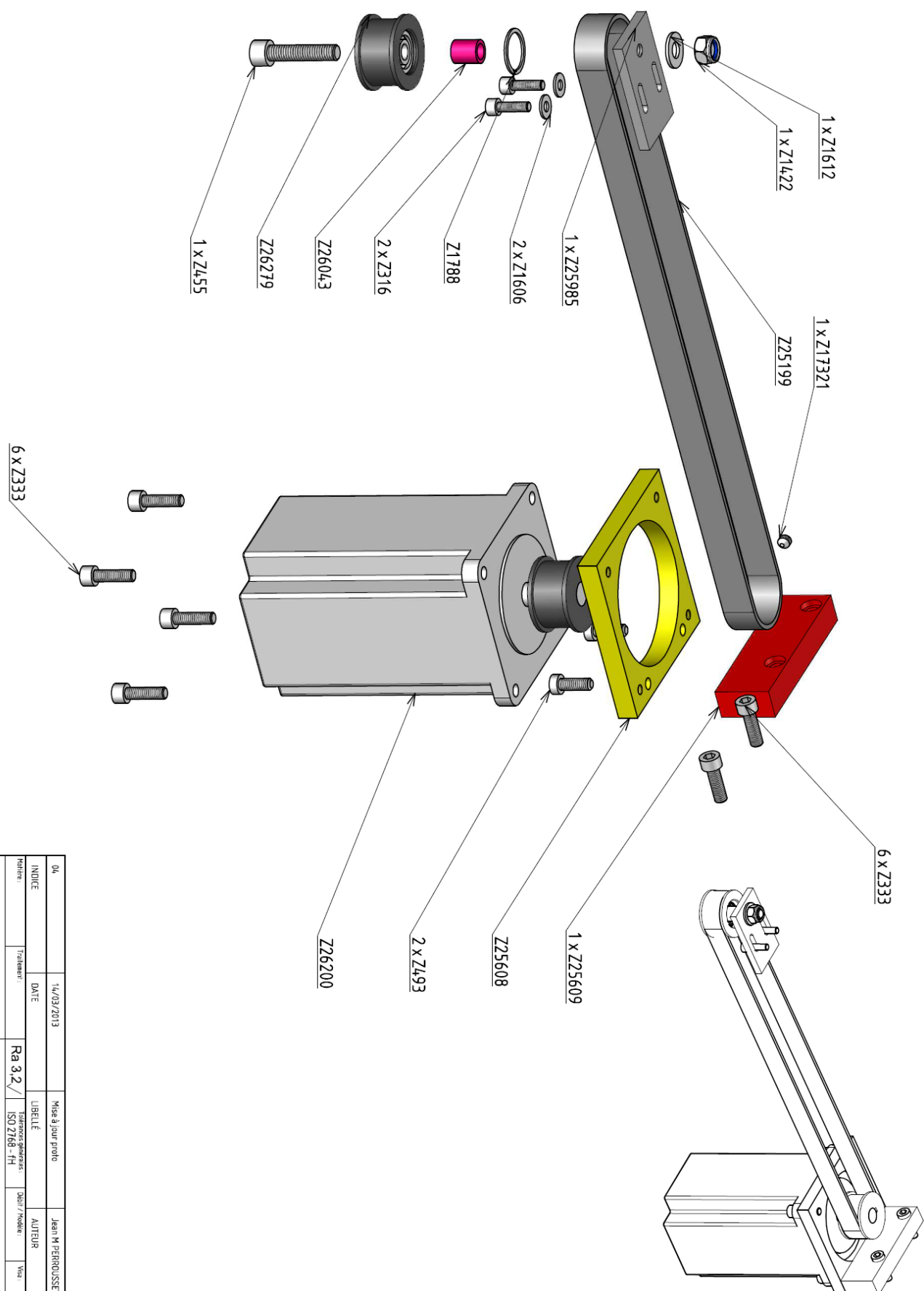
S/E SUPPORT CHARGEUR PNEUMATIQUE

INDICE		DATE		LIBELLÉ		AUTEUR	
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Ra 3,2 /		ISO 2768 - fH		Visa :			
Z1. VERNEUIL, LETANG 77390 VERNEUIL, LETANG							
		S/E SUPPORT CHARGEUR PNEUMATIQUE					
Ech. :	Lc. :	Par. :	A3		N° Plan :	Z23390	Ind. :
1:1	30/03/2009	Jean M PERROUSSET					
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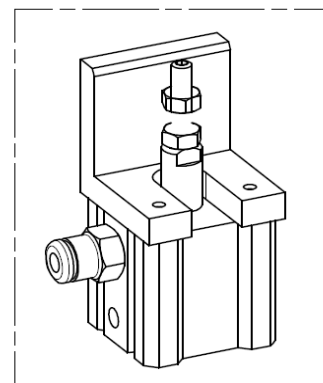
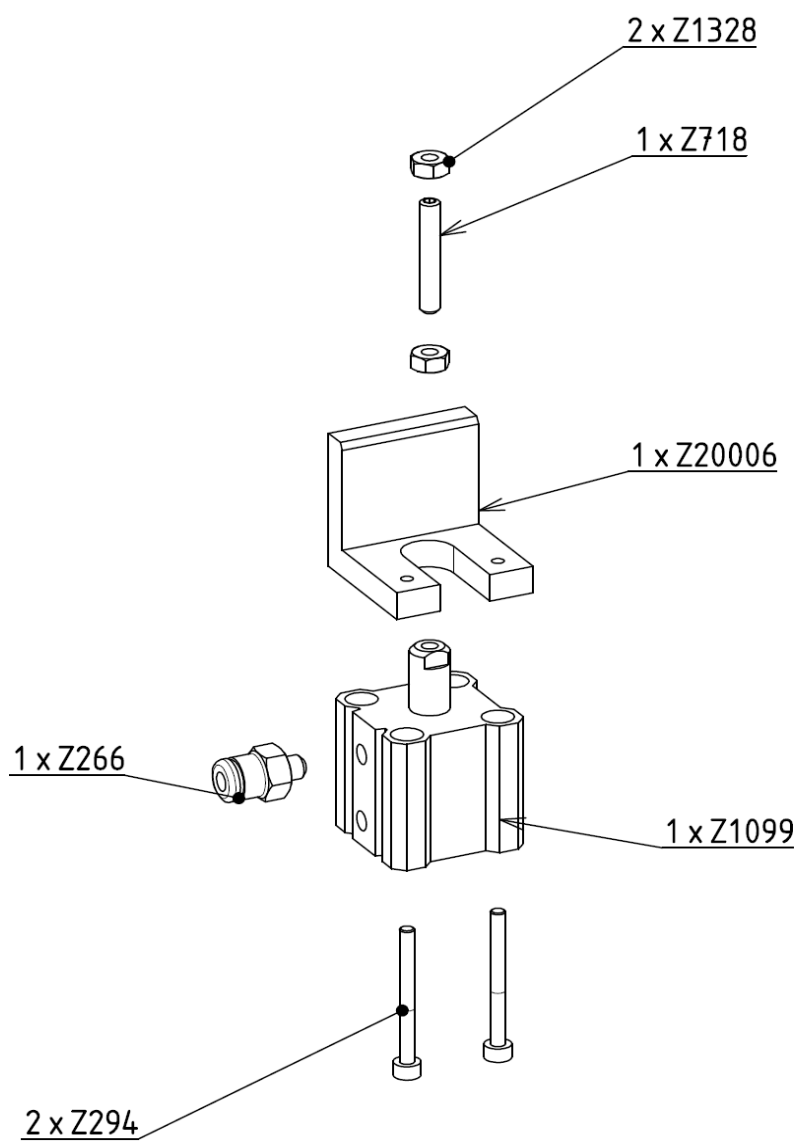


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 Z.I. VERNEUIL L'ETANG 77390 VERNEUIL L'ETANG		S/E SUPPORT MARTEAU				
Ech : 0.800	Le : 18/12/2007	Par : Renaud CHEYROU	A3		N° Plan : Z23384	Ind : 02
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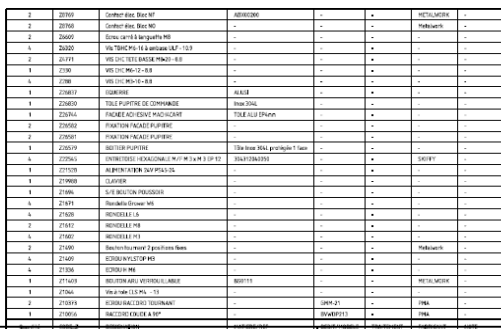


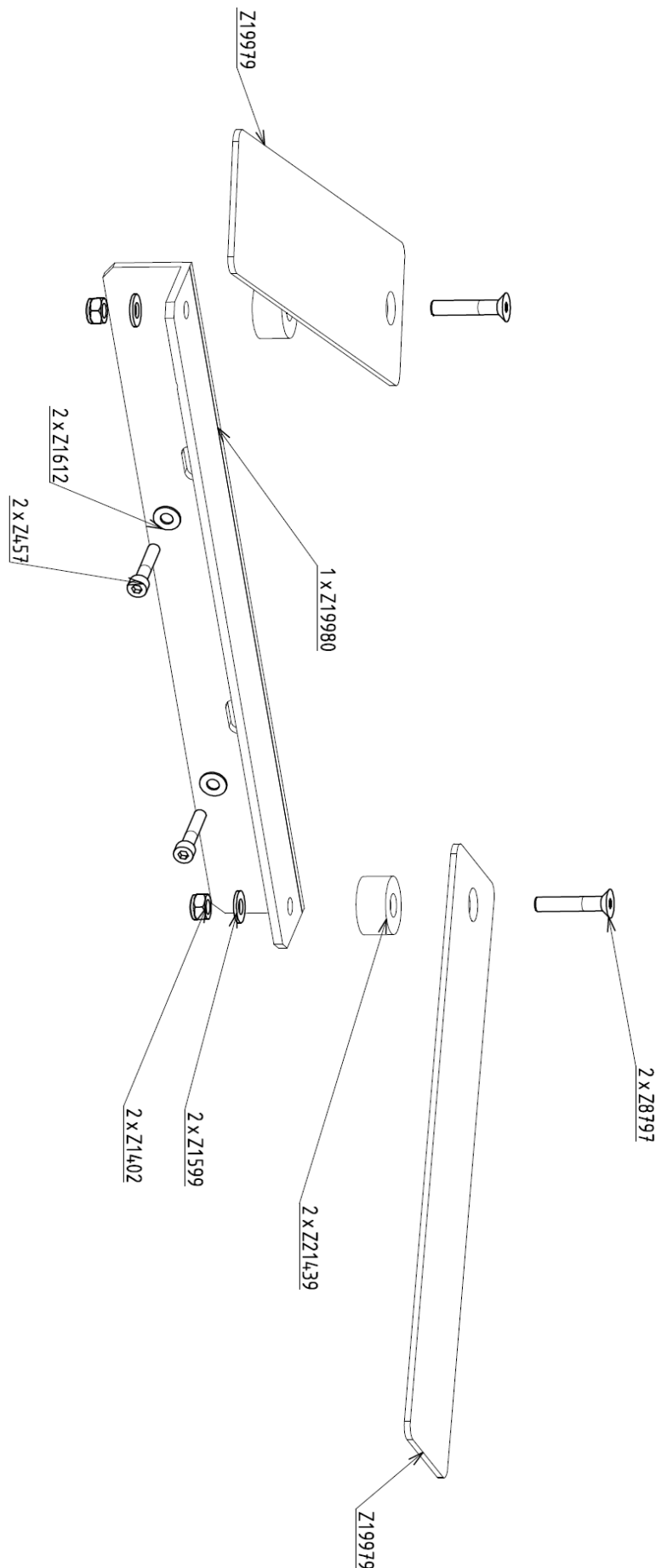
04.	14/03/2013	Mise à jour proto	Jean M PERROUSSET
INDICE	DATE		
Revisé	Traitement	LIBELLÉ	AUTEUR
		Tolérances générales	Mat.
		ISO 2768 - FH	Mat.
Cassese			
S/E MOTORISATION POSITION AGRAFAGE			
Edi 1	6/02/2013	N° Plan: Z25160	Ind: 04
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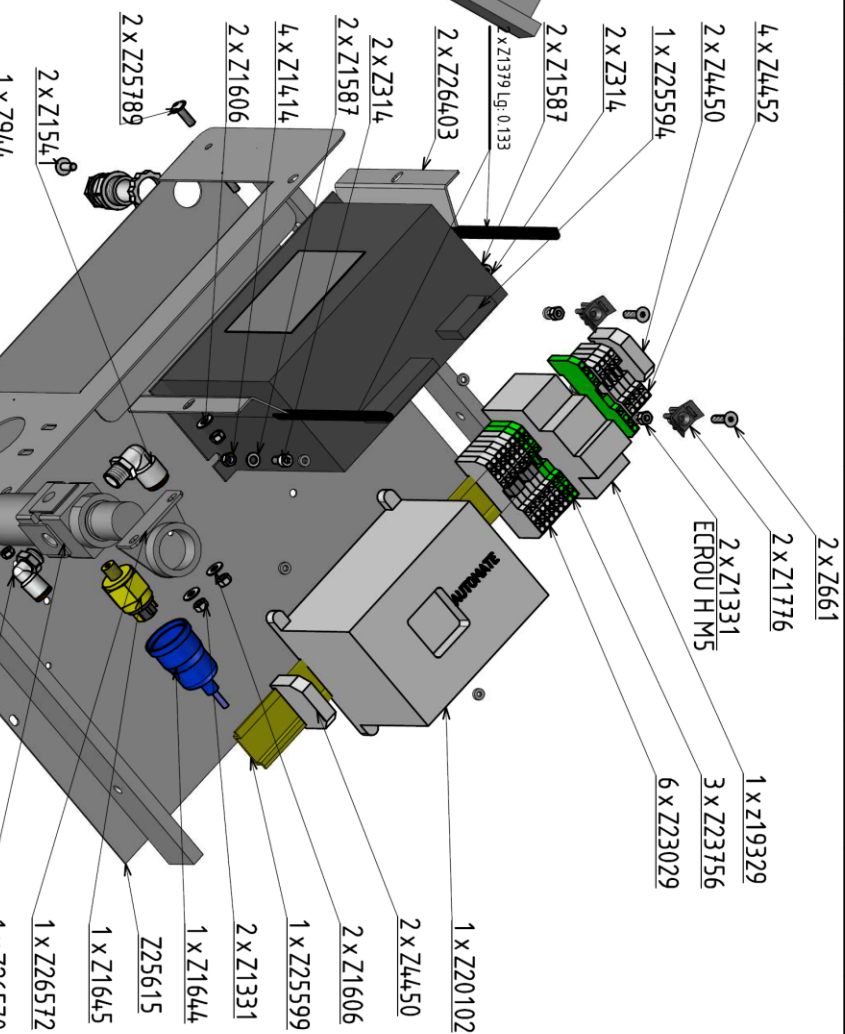
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Ech : 1:1	Le : 26/11/2007	Par : Renaud CHEYROU	A3	N° Plan : Z20005	Ind : 01
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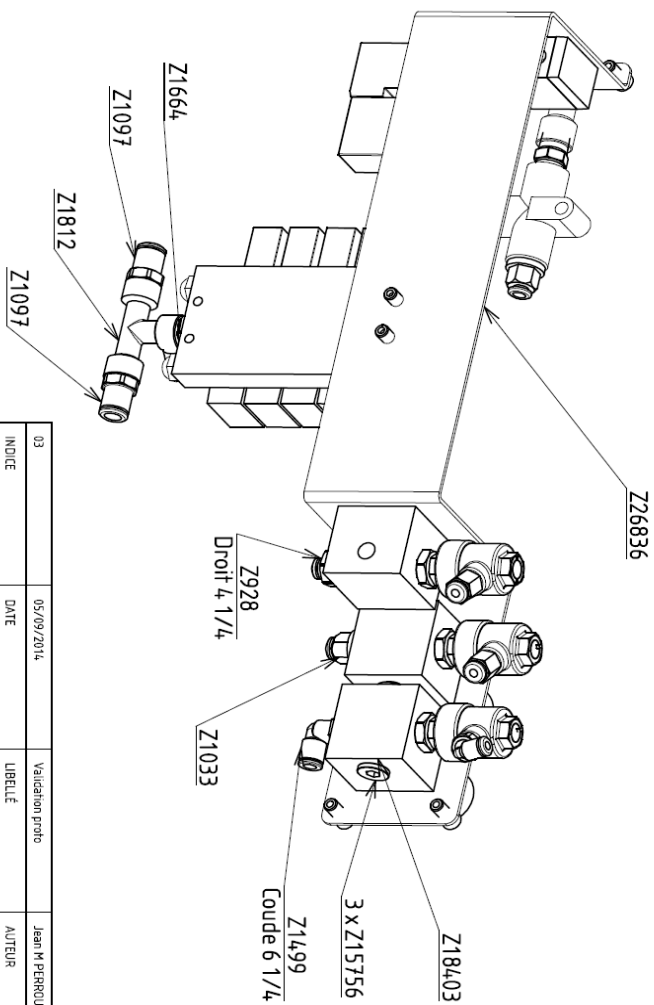
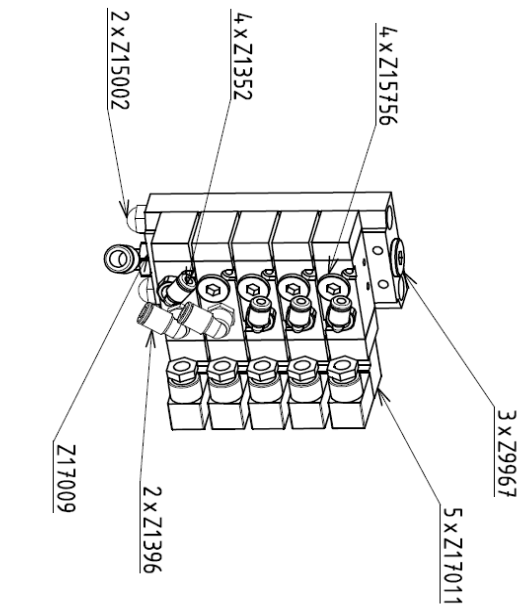
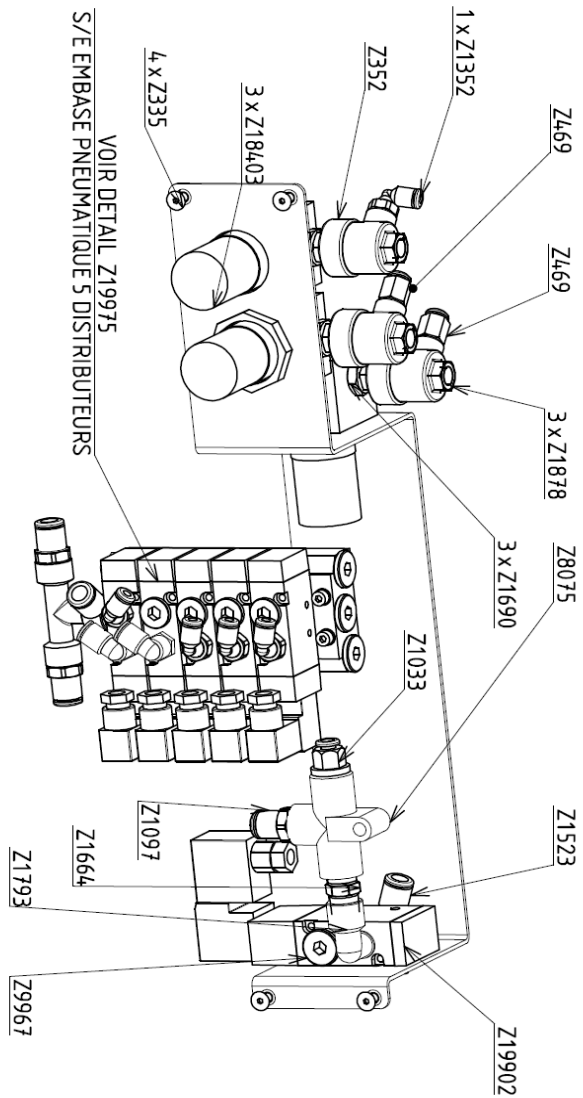


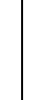

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S/E MAINTIEN CADRE					
Z1 VERNEUIL LETANG 7790 VERNEUIL LETANG					
Ed	1	1	1	N° Plan	225975
Ed	1	1	1	Ind	01
CE DOCUMENT EST A MONTRE DE LA SOCIETE CASSESE - NORD A TITRE COMPLEMENTAIRE. LE PLAN ET LE DEPOSEMENT DU COMMANDEMENT SONT AUTOMATIQUES.					



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200	17671	REF ID: A60847	REF ID: A60847
201	17670	REF ID: A60846	REF ID: A60846
202	17669	REF ID: A60845	REF ID: A60845
203	17668	REF ID: A60844	REF ID: A60844
204	17667	REF ID: A60843	REF ID: A60843
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217	17654	REF ID: A60830	REF ID: A60830
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221	17650	REF ID: A60826	REF ID: A60826
222	17649	REF ID: A60825	REF ID: A60825
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235	17636	REF ID: A60812	REF ID: A60812
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237	17634	REF ID: A60810	REF ID: A60810
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239	17632	REF ID: A60808	REF ID: A60808
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241	17630	REF ID: A60806	REF ID: A60806
242	17629	REF ID: A60805	REF ID: A60805
243	17628	REF ID: A60804	REF ID: A60804
244	17627	REF ID: A60803	REF ID: A60803
245	17626	REF ID: A60802	REF ID: A60802
246	17625	REF ID: A60801	REF ID: A60801
247	17624	REF ID: A60800	REF ID: A60800
248	17623	REF ID: A60799	REF ID: A60799
249	17622	REF ID: A60798	REF ID:

Part Name	Serialized	Part 32 /	Reference or Revision	Issue / Revision	Year
		RS 2188 - H1			
		S/E TRILOR COMPONENTS			
2) IDENTICA LITINGO TRILOR VENEZIA, LITINGO 1) 11/04/2015 1) 11/04/2015		Part / Revision A1	W Part Z26745	Ref:	



03	05/09/2014	Validation photo	Jean M PERROUSSET
INDICE	DATE	URGENT	AUTREUR
Pratère	Traitement :	Ra 3,2 / Effusé / Révisé / ISO 2168 - H1	Deux / Troisième : N° :
 S/E PLATINE PNEUMATIQUE			
Z1. VERNICUL. LETIANG 77500 VERNICUL. LETIANG			
E2 1.1 16/07/2014	1 16/07/2014 Jean M PERROUSSET	A2  N° Plan : Z26840	Int. : 03

IV. SPARE PARTS LIST / NOMENCLATURE

REFERENCE	QTY	UNIT	DESIGNATION	DESCRIPTION
30307NCOI	1	U	BTE 6 CHARGEURS COINS N° 7	BOX 6 CARTRIDGES #7
30310NCOI	1	U	BTE 6 CHARGEURS COINS N°10	BOX 6 CARTRIDGES #10
31310BDKO	1	U	BTE 6 CHARGEURS COINS N°10 BD	BOX 6 CARTRIDGES #10 HW
Z10055	1,00	m	GAINE ROBOTIQUE D:23 NOIR	WIRE PROTECTING BLACK TUBE D:23
Z10056	2	U	RACCORD 90° D:23	RACCORD 90° D:23
Z1033	2	U	DROIT 6 1/4	STRAIGHT CONNECTION 6 1/4
Z10373	2	U	ECROU GMM-21	ECROU GMM-21
Z1044	1	U	VIS AUTOTARAUDEUSE 4 X 13 ZINGUEE	AUTO TAPING SCREW 4 X 13
Z1097	1	U	DROIT 8 1/4	STRAIGHT CONNECTION 8 1/4
Z1097	3	U	DROIT 8 1/4	STRAIGHT CONNECTION 8 1/4
Z11061	1	U	COLLIER COLSON 9 X 350	TIE RAP 4.8 X 368
Z11403	1	U	BOUTON ARU VERROUILLABLE	BOUTON ARU VERROUILLABLE
Z12062	2	U	ENTRETOISE ACIER D: 10.1 X D: 25 X EP: 3	IRON SPACER D: 10.1 x D: 25 x EP: 3
Z12064	1	U	PALETTE CS55M-CS199MXL-CS299MXL2-CS4008XL-	PALET
Z12560	2	U	PALIER LISSE D: 20 D: 28 L:30	PLASTIC BEARING SLEAVES
Z1270	4	U	VIS HC M6-8 POINTEAU - 8.8	SCREW HC 6 X 8 POINTEAU
Z12724	2	U	DOUILLE A BILLES DOUBLE SM 20 X 32 X 80	BUSHING 20 X 32 X 80
Z1284	1	U	FICHE 10/16A 2P+T	PLUG 10/16A 2PHASE+GR.
Z13041	3	U	DROIT 10 1/4	STRAIGHT CONNECTOR 10 1/4
Z1311	1	U	VIS STF M 6 X 10 NYLON	SCREW STF M 6 X 10 NYLON
Z1314	1	U	COUDE 4M5	ELBOW 4 M 5
Z1328	2	U	ECROU H M 4	NUT
Z1331	2	U	ECROU H M 5	NUT
Z1331	4	U	ECROU H M 5	NUT
Z13331	2	U	DOUILLE A BILLES SM 30 X 45 X 64 G UU	LINEAR BEARING 30 X 45 X 64
Z1336	1	U	ECROU H M6	NUT
Z1353	4	U	DOUILLE A BILLES KH 20 X 28 X 30	LINEAR BEARING KH 20 X 28 X 30
Z1363	1	U	ECROU HM M20	FLAT NUT D.20
Z1378	1	U	ECROU HM M6	FLAT NUT D. 6
Z1394	1	U	POUSOIR A TETON (mini cde 5 pcs)	Wedge driver blade retaining screw (mini order 5 pcs)
Z1396	1	U	COUDE 6 1/8 ORIENTABLE	ELBOW 6 1/8
Z1398	1	U	ECROU NYLSTOP M 20	NUT NYLSTOP D.20
Z140	1	U	RONDELLE DE GRIFFE PIVOTANTE	WASHER FOR PIVOTING CLAMP
Z1402	2	U	ECROU NYLSTOP M 10	NUT NYLSTOP 10
Z14072	1	U	RESSORT COMP D: 0,7 DE: 8.3 LO: 27 7,5 SP	SPRING COMP D: 0,7 DE: 8.3 LO: 27 7,5 SP
Z14096	1	U	RESSORT COMP D: 3,6 DE: 49,5 LO: 185 9,5 SP	SPRING
Z1412	1	U	ECROU NYLSTOP M4	NUT NYLSTOP M4
Z1412	2	U	ECROU NYLSTOP M4	NUT NYLSTOP M4
Z1412	2	U	ECROU NYLSTOP M4	NUT NYLSTOP M4
Z1414	2	U	ECROU NYLSTOP M 5 zingué blanc 8.8	NUT NYLSTOP 5
Z1414	1	U	ECROU NYLSTOP M 5 zingué blanc 8.8	NUT NYLSTOP 5
Z1417	1	U	ECROU NYLSTOP M6	NUT NYLSTOP 6
Z1417	4	U	ECROU NYLSTOP M6	NUT NYLSTOP 6
Z1422	1	U	ECROU NYLSTOP M8	NUT NYLSTOP D. 8
Z14472	1	U	RONDELLE Z D: 20	WASHER D.20
Z14719	1	U	BUTOIR D'AGRAFAGE	STOP BAR
Z14722	2	U	VIS STF M 4 X 6 NYLON	NYLON SETSCREW M4X6
Z1478	1	U	BOUTON ETOILE F: M 4	STAR BUTTON M 4 F
Z1487	1,00	m	CABLE 1 X 0.75 NOIR	CABLE 1 X 0.75 BLACK
Z1490	2	U	BOUTON TOURNANT 2 POSIT. FIXES	BUTTON ZB2 BD2
Z1499	1	U	COUDE 6 1/4	ELBOW 6 1/4
Z1523	1	U	COUDE 8 1/4	ELBOW 8 1/4
Z1523	1	U	COUDE 8 1/4	ELBOW 8 1/4
Z1524	1	U	ROULEMENT A BILLES 8 X 22 X 7 608 2RS	BALL BEARING 8 X 22 X 7 608 2RS
Z1524	1	U	ROULEMENT A BILLES 8 X 22 X 7 608 2RS	BALL BEARING 8 X 22 X 7 608 2RS

REFERENCE	QTY	UNIT	DESIGNATION	DESCRIPTION
Z15290	1	U	PLAQUE SUPPORT CAPTEUR	SUPPORT PLATE
Z1536	1,00	m	TUBE P.U 2,5 X 4 BLEU (LE M)	PU ROLL TYPE 4 x 2.5 BLUE
Z1541	1	U	COUDE 10 1/4	ELBOW 10 1/4
Z1547	2,00	m	CABLE 1 X 0.75 VERT JAUNE	CABLE 1 X 0.75 YELLOW/GREEN
Z1549	1	U	CONNECTEUR MALE SUB.D (9 BR.)	CONNECTEUR MALE SUB.D (9 BR.)
Z1550	2,00	m	CABLE 2 X 0.75	CABLE
Z1555	3,00	m	CABLE 2 X 1.5	CABLE 2 x 1.5
Z1556	6	U	DIODE 1N4001	DIODE 1N4001
Z15710	1	U	VIS BHC A EMBASE ULF 6 X 10	BUTTON HEAD SCREW ULF 6 X 10
Z15710	7	U	VIS BHC A EMBASE ULF 6 X 10	BUTTON HEAD SCREW ULF 6 X 10
Z15756	3	U	BOUCHON M 1/8 CYL	CAP M 1/8 CYL
Z1585	8	U	RONDELLE Z D4	WASHER Z D4
Z1585	2	U	RONDELLE Z D4	WASHER Z D4
Z1587	1	U	RONDELLE Z D5	WASHER Z D5
Z1587	2	U	RONDELLE Z D5	WASHER Z D5
Z1588	4	U	RONDELLE Z6	WASHER Z6
Z1589	1	U	RONDELLE Z D: 12	WASHER Z 12
Z15906	1	U	RONDELLE NORD LOCK D: 12	WASHER NORD LOCK D:12
Z1599	2	U	RONDELLE M10	WASHER M D: 10
Z1599	2	U	RONDELLE M10	WASHER M D: 10
Z16028	1	U	BUTEE ELASTIQUE D: 15 X 10 M5 POLYURETHANE	RUBBER END FOR TOP (vertical) CLAMPS
Z1604	2	U	RONDELLE M4	WASHER M 4
Z1604	1	U	RONDELLE M4	WASHER M 4
Z1605	1,00	m	TUBE RILSAN 5 X 8 BLEU (LE M)	TUBE RILSAN 5 x 8 BLUE (BY METER)
Z1606	1	U	RONDELLE M5	WASHER
Z1606	2	U	RONDELLE M5	WASHER
Z1606	1	U	RONDELLE M5	WASHER
Z1606	4	U	RONDELLE M5	WASHER
Z1606	1	U	RONDELLE M5	WASHER
Z1608	1	U	RONDELLE M6	WASHER M 6
Z1608	1	U	RONDELLE M6	WASHER M 6
Z1612	1	U	RONDELLE M8	WASHER M 8
Z1612	2	U	RONDELLE M8	WASHER M 8
Z1612	5	U	RONDELLE M8	WASHER M 8
Z1619	1	U	MANCHON F 1/4	COUPLING SLEEVE F 1/4
Z16294	1	U	COUDE 4 1/8 ORIENTABLE HAUT 4 1/8	ELBOW 4 1/8
Z1644	1	U	CAPUCHON PRESSOSTAT	COVER OF MANOCONTACT
Z1645	1	U	PRESSOSTAT	MANOCONTACT
Z1662	1	U	PEDALE ELECTRIQUE	ELECTRICAL PEDAL
Z1664	4	U	MAMELON M 1/4 CON	NIPPLE 1/4
Z1664	2	U	MAMELON M 1/4 CON	NIPPLE 1/4
Z1671	1	U	RONDELLE GROWER D: 6	WASHER GROWER D: 6
Z1671	4	U	RONDELLE GROWER D: 6	WASHER GROWER D: 6
Z16771	2	U	DOUILLE A BILLES SM 16 X 28 X 37 G UU	LINEAR BEARING 16 X 28 X 37 G UU
Z1685	2	U	RONDELLE EVENTAIL D.8	RONDELLE EVENTAIL D.8
Z1688	1	U	REGLET 0 - 500	SCALE 0 - 500
Z1690	3	U	REDUCTION M 1/4 M 1/8 CYL	REDUCTION M 1/4 M 1/8 CYL
Z16914	6,00	m	CABLE BLINDE 4 X 0.75	CABLE 4X0.75
Z1694	1	U	S/E BOUTON DE COMMANDE NOIR + NO	SUB ASSY PUSH BUTTON
Z1697	1,00	m	BITUBE PU 2,5 X 4 BLEU/NOIR (LE M)	TUBE PU 2,5 X 4 BLUE/BLACK (BY METER)
Z17	1	U	RESSORT DE GRIFFE	CLAW SPRING
Z1709	1	U	REDUCTION M 1/2 F 1/4	REDUCTION M 1/2 F 1/4
Z1710	2	U	ROULEMENT A BILLES 4 X 12 X 4 604 ZZ	ROULEMENT A BILLES 4 X 12 X 4 604 ZZ
Z17397	1	U	ENTRETOISE POLYURETHANE D: 6.2 X D: 14.5 X EP: 3	SPACER
Z17414	1	U	BUTEE POM D: 14 LG: 34 M6	RETRACTABLE JAWS PLASTIC FINGER
Z1776	4	U	EMBASE A VISSER	BASE
Z1776	1	U	EMBASE A VISSER	BASE
Z1776	2	U	EMBASE A VISSER	BASE

REFERENCE	QTY	UNIT	DESIGNATION	DESCRIPTION
Z1778	2	U	ECROU DE PRESSE ETOUPE N°13	NUT FOR STUFFING BOX N°13
Z1788	1	U	CIRCLIPS INT D: 22	CIRCLIPS INT D: 22
Z1793	1	U	COUDE M 1/4 CON F 1/4 CYL	ELBOW 1/4 MF
Z1801	2	U	PRESSE ETOUPE N°13	STUFFING BOX N°13
Z1810	1	U	SERRE CABLE CV-8 D. 8	CLAMPING RING D.8
Z1812	1	U	TE F 1/4 CYL	TE F 1/4 CYL
Z18374	1	U	BARREAU AV FONDERIE USINE	ALUMINUM CAST BLOCK
Z18387	1	U	VERIN DOUBLE EFFET MAGNETIQUE D.10 C.150	RODLESS MAGNETIC CYLINDER DOUBLE EFFECT
Z18403	3	U	MICROREGULATEUR	AIR REGULATOR
Z18444	1	U	RONDELLE NORD LOCK D: 20	WASHER NORD LOCK D:20
Z18450	1	U	S/E BARREAU DE GRIFFES ESCAMOTABLES Ø 40	CLAMPING PISTON ASSEMBLY
Z18451	1	U	SUPPORT VERIN DE SERRAGE	CLAMPING PISTON SUPPORT
Z18453	1	U	SUPPORT DE GRIFFES	CLAMP SUPPORT
Z18473	1	U	PLAQUE PRINCIPALE GAUCHE USINEE	MAIN LEFT TABLE
Z18474	1	U	PLAQUE PRINCIPALE DROITE USINEE	MAIN RIGHT TABLE
Z1873	3	U	SILENCIEUX 1/8	MUFFLER 1/8
Z19051	1	U	SUPPORT CHARGEUR USINE VERIN EMC	MACHINED CARTRIDGE SUPPORT EMC PISTON
Z19054	1	U	TOLE SUPPORT VERIN POUSSE AGRAFES	PISTON SUPPORTING PLATE
Z19064	1	U	S/E COULISSEAU VERIN EMC D 6	SLIDER ASSY EMC PISTON
Z1915	3	U	DÉTECTEUR DE PROXIMITÉ NPN,NO	INDUCTIVE SENSOR NPN NO
Z19222	2	U	VIS HC 20 X 70	SCREW HC 20 X 70
Z19240	1	U	VERIN D.80 C.100 RALLONGE +11 MM	CYLINDER D.80 C.100
Z19281	1	U	CONNECTEUR MOLEX 4 PTS FEMELLE	CONNECTEUR MOLEX 4 PTS FEMELLE
Z19282	4	U	CONTACT A SERTIR MOLEX	CONTACT A SERTIR MOLEX
Z19329	1	U	DISJONCTEUR 1P+N 4AD	SURGE PROTECTION
Z19332	1	U	EMBALLAGE 700 X 655 X 1250 INTER. CLOCHE+COUVERCLE	BOX
Z19653	1	U	AMPLI FIBRE OPTIQUE	OPTICAL FIBER SENSOR AMPLIFIER
Z19766	1	U	UNION D 4	JUNCTION CONNECTOR D 4
Z19855	1	U	S/E VALVE D'ECHAPP. RAPIDE 1/2 EQUIPEE	QUICK EXHAUST VALVE
Z19902	1	U	DISTRIBUTEUR 4V210-08 24V DC	SOLENOID VALVE V210-08 24V DC
Z19932	1	U	S/E MANETTE DE BLOCAGE DE TABLE	FENCES TABLE LOCKING HANDLE
Z19948	1	U	AXE DE SUPPORT MARTEAU	HAMMER SUPPORT AXIS
Z19975	1	U	S/E EMBASE PNEUMATIQUE EQUIPEE EMC	VALVES SUB ASSY
Z19979	2	U	PLAQUE SUPPORT CADRE	FRAME SUPPORT PLATE
Z19980	1	U	EQUERRE SUPPORT CADRE	SUPPORT
Z19988	1	U	ECRAN TACTILE DOP-B05	TACTILE DOP-B05 SCREEN
Z20005	1	U	S/E VERIN PRE SERRAGE DE GRIFFES	SUB ASSY PRE CLAMPING PISTON
Z20102	1	U	AUTOMATE CP1L-M30DT-D	PROCESSOR UNIT CP1L-M30DT-D+ PROGRAM.
Z20103	1	U	INTERFACE RS232 CP1W-CIF01	INTERFACE RS232 CP1W-CIF01
Z21218	1,00	m	TUBE P.U 6 X 8 BLEU (LE M)	PU ROLL TYPE 6 x 8 BLUE
Z21439	2	U	RONDELLE PLASTIQUE D 40 X 8.2 EP 20	PLASTIC SPACER D 40 X 8.2 EP 20
Z21492	1	U	JOINT METALOPLASTIQUE MPF 24 X 32 X 2.5	O-RING
Z21499	1	U	BOUCHON POUR ECROU M.20	CAP PLUG FOR NUT M20
Z21527	1	U	CALE CTP 19 X 50 H: 225	SPACER
Z21528	1	U	ALIMENTATION 24V	ALIMENTATION 24V
Z21613	1	U	PLAQUE BUTEE INJECTION ALU USINEE PEINTE	STOP PLATE
Z21731	2	U	ENTRETOISE PLASTIQUE D: 5.2 X D: 10 X LONG 25	SPACER 5.2 x 10 x 25
Z22103	3	U	VIS BHC A EMBASE ULF 5 X 12 10.9	SCREW BHC 5 x 12
Z22103	4	U	VIS BHC A EMBASE ULF 5 X 12 10.9	SCREW BHC 5 x 12
Z22103	12	U	VIS BHC A EMBASE ULF 5 X 12 10.9	SCREW BHC 5 x 12
Z22104	1	U	VIS HC 8 X 30	HEAD SET SCREW 8X30
Z22303	1	U	CONNECTEUR MOLEX 6PTS	CONNECTEUR MOLEX 6PTS
Z22355	1	U	ANNEAU D'ARRET A ARCBOUTEMENT Ø 8	LOCKING WASHER
Z22391	1	U	ENTRETOISE ACIER D: 8.2 X D: 15 X EP: 5.1	SPACER
Z22402	2	U	VIS TC FENDUE M2.5 X 20	SCREW CYLINDER HEAD M2.5 X 20
Z22438	1	U	PLANCHE AGGLOMEREE 650 mm x 695 mm EP: 22	WOOD PLATE
Z22521	1	U	SUPPORT DETECTEUR	SENSOR SUPPORT
Z22545	4	U	ENTRETOISE HEXAGONALE M/F M 3 x M 3 EP 12	HEXAGONAL SPACER

REFERENCE	QTY	UNIT	DESIGNATION	DESCRIPTION
Z22761	1	U	GRIFFE COURTE COULISSANTE	SLIDING CLAMP
Z22762	1	U	GRIFFE COURTE PIVOTANTE AFFLEURANTE	ROTATING CLAMP
Z22763	1	U	S/E GRIFFES ASSEMBLEUSE	SUB ASSY CLAMP
Z22856	1	U	SUPPORT FIBRE OPTIQUE	STRUT
Z22857	1	U	ENTRETOISE ACIER D: 4.1 X D: 6 X EP: 7	STRUT
Z22866	3	U	RESISTANCE 1.2KOHMS 1/4W	RESISTOR 1.2 KOHMS
Z22887	1	U	SUPPORT FIBRE OPTIQUE	STRUT
Z23029	6	U	BORNE DE PASSAGE POUR 4 CONDUCTEURS	4 CONDUCTORS TERMINAL
Z23351	1	U	PORTE BAGUE D' ETANCHEITE	SEALING PROTECTION
Z23354	1	U	COLONNE DE POTENCE D: 30 / D: 16 LG: 415	SHAFT D: 30 / D: 16 LG: 415
Z23361	1	U	SUPPORT VERIN D' AGRFAGE	STAPLING PISTON SUPPORT
Z23384	1	U	S/E SUPPORT MARTEAU	WEDGE DRIVER BLADE SUPPORT ASSY
Z23390	1	U	S/E SUPPORT CHARGEUR PNEUMATIQUE	SUB ASSY CARTRIDGE SUPPORT
Z23392	1	U	S/E FIBRES OPTIQUES	SUB ASSY OPTICAL FIBER
Z23440	1	U	S/E BUTEE AGRAFAGE	SUB ASSY
Z23756	3	U	BORNE DE PROTECTION 4 CONDUCTEURS	4 CONDUCTORS PROTECTION
Z23813	1	U	S/E PISTON Ø 40 MODIFIE	CYLINDER D 40 MODIFIED
Z23945	1	U	BARREAU DE GRIFFES ESCAMOTABLES	CLAMP SUPPORT ALUMINUM CAST
Z24156	2	U	VIS CHC 8 X 45 TETE BASSE ZINGUEE 10.9	SCREW CHC 8 X 45
Z24460	1	U	POULIE RECEPTRICE 20 AT5-0/20-2	PULLEY
Z24861	1	U	ECROU POM SPEEDY 16/90 (A DROITE)	QUICK DRIVING NUT
Z24913	1	U	MOTEUR PAS A PAS HIGHTORQUE ARBRE Ø 12	MOTOR W/O GEARS FOR ULTRAS
Z24940	0,00	m	CABLE 1 x 0,34 BLANC	WIRE END SECTION 0.34 WHITE
Z24941	0,00	m	CABLE 1 x 0.34 MARRON	WIRE END SECTION 0.34
Z25028	0,00	m	CABLE 1 x 0,34 ROUGE	WIRE END SECTION 0.34 RED
Z25064	1	U	PLAQUE SUPPORT DE GRIFFES	CLAMP SUPPORT
Z25160	1	U	S/E MOTORISATION POSITION AGRAFES	SUB ASSY STAPLING POSITION MOTOR
Z25199	1	U	COURROIE 16 AT 5 LG 750	TRANSMISSION BELT
Z25215	0,00	m	BANDE EPDM COLLE 1 FACE 10 X 5	SEALING ADHESIV TAPE
Z25394	1	U	VIS RAPIDE SPEEDY P= 90 Ø16 LG: 51 PAS A DROITE	QUICK SCREW
Z25395	1	U	BIELLE DE GRIFFE ESCAMOTABLE	QUICK DRIVING NUT
Z25396	2	U	COLONNE D: 16 LG: 60 USINEE	SHAFT D: 16 LG: 60
Z25594	1	U	DRIVER ZM-3H2080 PAS A PAS 3 PHASES 110-220V	DRIVER ZM-3H2080 PAS A PAS 3 PHASES 110-220V
Z25599	1	U	RAIL OMEGA LG: 270	SUPPORTING RAIL
Z25608	1	U	SUPPORT MOTEUR	MOTOR SUPPORT
Z25609	1	U	PLAQUE SUPPORT MOTEUR	MOTOR SUPPORT PLATE
Z25613	1	U	LESTE BETON	CONCRETE BALLAST
Z25615	1	U	COFFRET COMPOSANTS	ELECTRIC CABINET FRAME
Z25789	4	U	VIS BHC A EMBASE ULF 5 X 16 ZINGUEE 10.9	SOCKET BUTTON HEAD SCREW M5 x 16 WITH FLANGE
Z25876	1	U	EQUERRE ARRIERE	COVER PLATE
Z25877	1	U	TOLE SECURITE POTENCE	COVER PLATE
Z25931	4	U	FIXATION PANNEAU	PANNEL SUPPORT
Z25932	2	U	BUTTE D' ARRET	STOP
Z25975	1	U	S/E MAINTIEN CADRE	FRAME SUPPORT ARMS
Z25985	1	U	TENDEUR	TENSIONER
Z25986	2	U	RAIL TELESCOPIQUE 3 ELEMENTS	RAIL
Z25988	1	U	BARREAU AR USINE	CAST COLUMN SUPPORT
Z25995	2	U	PLAT FIXATION RAIL	PLAT FIXATION RAIL
Z26043	1	U	ENTRETOISE ACIER D: 8.2 X D: 12 X EP: 13	SPACER d 8.2 X D 12 X H 13
Z26107	2,00	m	CABLE 20 X 0.34 (LE M)	CABLE 20 X 0.34
Z26150	1	U	S/E SUPPORT MARTEAU ET POUSSOIR ASSEMBLE	HAMMER SUPPORT ASSY
Z26191	1	U	POULIE MOTRICE 20 AT5-0/20-2 ALESAGE Ø 12	MOTOR PULLEY
Z26206	1	U	BARREAU INFERIEUR	ACCOSTER BOTTOM BAR
Z26207	2	U	PRESSE ETOUPE N°21	STUFFING BOX N°21
Z26208	2	U	ECROU DE PRESSE ETOUPE N°21	NUT FOR STUFFING BOX N°21
Z26223	1	U	PINCE A COURROIE AT5	BELT CLAMP
Z26224	1	U	EQUERRE DE DETECTION AGRAFAGE	EQUERRE DE DETECTION AGRAFAGE
Z26228	1,00	m	BANDE EPDM COLLE 1 FACE 15 X 15	SEALING ADHESIV TAPE

REFERENCE	QTY	UNIT	DESIGNATION	DESCRIPTION
Z26251	1	U	S/E VALVE D'ECHAPP. RAPIDE 1/2 EQUIPEE	QUICK EXHAUST VALVE
Z26403	2	U	DEFLECTEUR	DEFLECTOR
Z26515	1	U	VIS BHC A EMBASE ULF 4 X 20 10.9	VIS BHC A EMBASE ULF 4 X 20
Z26570	1	U	FILTRE REGULATEUR 1/4 AW20-F02	AIR CONDITIONNER
Z26572	1	U	EQUERRE DE FIXATION FILTRE REGULATEUR	SQUARE SUPPORT
Z26578	1	U	S/E PUPITRE DE COMMANDE MACH4CART	CONTROL PANEL SUB ASSY
Z26579	1	U	BOITIER PUPITRE	BOITIER PUPITRE
Z26581	2	U	FIXATION FACADE PUPITRE	CONTROL PANEL SUPPORT
Z26582	2	U	FIXATION FACADE PUPITRE	CONTROL PANEL SUPPORT
Z26591	1	U	MICROSWITCH A GALET D453-V1RA	MICROSWITCH
Z26596	1	U	LIMITEUR DE DEBIT FIXE Ø 0.5	FLOW REDUCER
Z266	2	U	DROIT 4M5	STRAIGHT CONNECTION 4 M 5
Z266	1	U	DROIT 4M5	STRAIGHT CONNECTION 4 M 5
Z26676	2	U	BANDE ADHESIVE PA6 25.4 X 0.25 LG:220MM	PROTECTING TAPE
Z26687	1	U	BRIDE DE COURROIE	BELT LOCKING PLATE
Z26724	1	U	BARREAU D'AGRAFAGE FONDERIE USINE MACH4CART	MACHINED DISTRIBUTOR CAST SUPPORT
Z26725	1	U	ENSEMBLE MECANIQUE COMMUNE CART	SUB ASSY CARTRIDGE VERSION
Z26741	1	U	MANUEL TECHNIQUE ET D'UTILIS. MACH4CART	MANUEL TECHNIQUE ET D'UTILIS. MACH4CART
Z26742	1	U	S/E EMBALLAGE MACH4CART	PACKING SUB ASSY
Z26744	1	U	FACADE ADHESIVE MACH4CART	FACADE ADHESIVE MACH4CART
Z26745	1	U	S/E TIROIR COMPOSANTS MACH4	SUB ASSY ELECTRICAL COMPARTMENT TROLLEY
Z26770	1	U	S/E BATI MACH CART	FRAMING SUB ASSY
Z26771	1	U	S/E PANNEAUX ROUGES CART	SUB ASSY RED PANELS
Z26809	1	U	DOIGT D' INDEXAGE	LOCATING PIN
Z26827	1	U	PLANCHE D'ETIQUETTES MACH4 CART	BOARD OF LABELS MACH4 CART
Z26830	1	U	TOLE PUPITRE DE COMMANDE	CONTROL PANEL PLATE
Z26836	1	U	TOLE SUPPORT PNEUMATIQUE	SUPPORT PLATE
Z26837	1	U	EQUERRE	T SUPPORT
Z26840	1	U	S/E PLATINE PNEUMATIQUE	PNEUMATIC SUB ASSY
Z26864	1	U	CAME DE DETECTION	DETECTION CAM
Z26875	1	U	VANNE CADENASSABLE 1/4	VALVE 1/4
Z26877	1	U	ENTRETOISE PLASTIQUE D: 5.2 X D: 10 X EP: 20	SPACER D: 5.2 X D: 10X EP: 20
Z26886	1	U	LARDON	GUIDE
Z26891	1	U	S/E PLAQUE BUTEE EQUIPEE	SLIDING TABLE WITH ADJUSTABLE FENCES
Z26918	1	U	ETIQUETTE SECURITE LIRE LE MANUEL	SAFETY LABEL
Z26953	1	U	AXE	AXIS
Z26954	1	U	CORPS	BODY
Z26957	1	U	RESSORT COMP	COMPRESSION SPRING
Z26980	1	U	S/E COLONNE + SUPPORTS VERIN ET PRESSEUR	COLUMN SUB ASSY
Z26983	1	U	ETIQUETTE SECURITE TENSION REF 307 Lg/ 25	SAFETY LABEL
Z26990	1	U	S/E SUPPORT PRESSEUR + AIMANT	SUB ASSY VERTICAL CLAMP SUPPORT
Z26993	1	U	ENTRETOISE ELASTOMERE 70 35 X 50 X EP: 15	RUBBER SPACER
Z27000	1	U	S/E BOITE ACCESSOIRES MACH4CART	SUB ASSY ACCESSORY BOX
Z2755	2	U	VIS CHC M4-35 - 8.8	SCREW CHC 4 X 35
Z2756	1	U	VIS BHC M6-20 - 10.9	SCREW BHC 6 X 20
Z2798	1,00	m	PAPIER ANTIROUILLE (LE KG) VOIR COMMENTAIRES	RUST PROTECTION PAPER
Z288	2	U	VIS CHC 3 X 10	SOCKET CAP SCREW M3 X 10
Z290	2	U	VIS CHC M3-16 - 8.8	SCREW CHC 3 X 16
Z290	4	U	VIS CHC M3-16 - 8.8	SCREW CHC 3 X 16
Z299	2	U	VIS CHC M4-10 - 8.8	SCREW CHC 4 X 10
Z302	1	U	VIS CHC M4-16 - 8.8	SCREW CHC 4 X 16
Z305	2	U	VIS CHC M4-30 - 8.8	SCREW CHC 4 X 30
Z306	2	U	VIS CHC M4-40 - 8.8	SCREW CHC 4 X 40
Z307	8	U	VIS CHC M4-45 - 8.8	SCREW CHC 4 X 45
Z311	1,00	m	CABLE 1 X 0.75 BLEU	CABLE 1 x 0.75 BLUE
Z312	1	U	VIS CHC 5 X 8	SOCKET CAP SCREW M5 X 8
Z312	2	U	VIS CHC 5 X 8	SOCKET CAP SCREW M5 X 8
Z314	2	U	VIS CHC M5-10 - 8.8	SOCKET CAP SCREW M5 X 10

REFERENCE	QTY	UNIT	DESIGNATION	DESCRIPTION
Z316	2	U	VIS CHC M5-16 - 8.8	SCREW CHC 5 X 16
Z317	1	U	VIS CHC M5-20 - 8.8	SOCKET CAP SCREW M5 X 20
Z319	1	U	VIS CHC M5-30 - 8.8	SOCKET CAP SCREW M5 X 30
Z330	1	U	VIS CHC M6-12 - 8.8	SCREW CHC 6 X 12
Z331	1	U	VIS CHC M6-16 - 8.8	SOCKET CAP SCREW M6 X 16
Z333	6	U	VIS CHC M6-20 - 8.8	SCREW CHC 6 X 20
Z334	4	U	VIS CHC M6-25 - 8.8	SCREW CHC 6 X 25
Z335	6	U	VIS FHC M4-12 - 8.8	SCREW FHC 4 X 12
Z336	2	U	VIS CHC M6-30 - 8.8	SCREW CHC 6 X 30
Z348	3,00	m	CABLE 3 X 1.5	CABLE 3 x 1.5
Z3498	1	U	S/E BUTEE FIXE	SUB ASSY STOP
Z3499	1	U	S/E BUTEE REGLABLE	SUB ASSY ADJUSTABLE STOP
Z352	3	U	PURGE RAPIDE 1/8	QUICK EXHAUST VALVE 1/8
Z4450	2	U	BUTEE D'ARRET SANS VIS	STOP WITHOUT SCREW
Z4451	4	U	CONTACT DE PONTAGE HORIZONTAL	HORIZONTAL CONNECTNG PLUG
Z4452	4	U	BORNE DE PASSAGE POUR 2 CONDUCTEURS	2 CONDUCTORS TERMINAL
Z4460	2	U	VIS HC 4 X 6 POINTEAU	SCREW HC 4 X 6 POINT END
Z455	1	U	VIS CHC M8-35 - 8.8	SCREW CHC 8 X 35
Z457	2	U	VIS CHC 8 X 45	SCREW CHC 8 X 45
Z469	2	U	DROIT 4 1/8	MALE TUBE CONNECTOR 4 1/8
Z4715	4	U	ETIQUETTE DE REPERAGE +24V/-24V BORNE WAGO	LABEL +24V/-24V WAGO
Z4771	2	U	VIS CHC 8 X 20 TETE BASSE ZINGUEE	SOCKET CAP SCREW M8 X 20 FLAT HEAD
Z4771	2	U	VIS CHC 8 X 20 TETE BASSE ZINGUEE	SOCKET CAP SCREW M8 X 20 FLAT HEAD
Z4771	1	U	VIS CHC 8 X 20 TETE BASSE ZINGUEE	SOCKET CAP SCREW M8 X 20 FLAT HEAD
Z481	2	U	VIS CHC TETE BASSE M4-10 - 8.8	SCREW CHC 4 X 10 FLAT HEAD
Z486	2	U	VIS CHC TETE BASSE M5-10 - 8.8	SCREW CHC 5 X 10 FLAT HEAD
Z493	2	U	VIS CHC 6 X 16 TETE BASSE	SCREW CHC 6 X 16 FLAT HEAD
Z497	1	U	ETIQUETTE CASSESE FRANCE	LABEL CASSESE FRANCE
Z4998	1	U	CONNECTEUR FEMELLE SUB (9BR)	FEMALE CONNECTOR SUB (9BR)
Z506	1	U	MARTEAU COURT (mini cde 5 pcs)	Short wedge driver blade (mini order 5 pcs)
Z5343	1	U	RONDELLE DE GRIFFES PIVOTANTES AFFLEURANTES	WASHER OF PIVOTING REBATE CLAMP
Z5417	1	U	ENTRETOISE ACIER D: 12.2 D : 17 EP : 1.1	WASHER UNDER PIVOTING REBATE CLAMP
Z557	2	U	VIS FHC 3 X 6	SCREW FHC 3 X 6
Z5838	1	U	AXE DE GRIFFE	AXE DE GRIFFE
Z5840	1	U	LEVIER DE GRIFFES	CLAMP LEVER
Z5842	1	U	ENTRETOISE ACIER D: 12 X D: 16 X EP: 5.5	CLAMP AXLE INSERT & BALL BEARING
Z5846	1	U	LARDON DE GRIFFE	INSERT
Z5847	1	U	GOUPILLE CYL 8X14	PIN CYL 8 X 14 DIN 6325
Z5849	2	U	COLONNE D: 20 LG: 414	SHAFT D: 20 LG: 414
Z5850	3	U	VIS CHC 10 X 16 TETE BASSE	SCREW CHC 10 X 16 FLAT HEAD
Z5953	1	U	RLT À 2 RANGÉE DE BILLES À CONTACT OBLIQUE	ROULEMENT A BILLES CT OBL 12 x 21 x 7 3801 2RS
Z5954	1	U	PALIER DE GRIFFE	PALIER DE GRIFFES
Z621	1	U	VIS DE REGLAGE GRIFFE	CLAMP ADJUSTEMENT SCREW
Z6219	2,00	m	CABLE 2 X 0.34	CABLE 2 x 0.34
Z6320	4	U	VIS BHC A EMBASE ULF 6 X 16	SCREW BHC WITH BASE ULF 6 X 16
Z6320	9	U	VIS BHC A EMBASE ULF 6 X 16	SCREW BHC WITH BASE ULF 6 X 16
Z649	2	U	VIS FHC 4 X 8	SCREW FHC 4 X 8
Z651	4	U	VIS FHC 4 X 16	SCREW FHC 4 X 16
Z6545	1	U	VIS CHC M6-55 - 8.8	SCREW CHC 6 X 55
Z6555	1	U	PLAQUE	PLATE
Z657	4	U	VIS FHC M5-10 - 8.8	SCREW FHC 5 X 10
Z6609	2	U	ECROU CARRE A LANGUETTE M 8	SQUARE NUT WITH SPRING PLATE M 8
Z661	2	U	VIS FHC 5 X 20	SCREW FHC 5 X 20
Z667	2	U	VIS FHC M6-12 - 8.8	SCREW FHC 6 X 12
Z675	1	U	EMBOUT MALE RAPIDE M 1/4	1/4 MALE CONNECTION
Z705	1	U	VIS HC M3-3 - 8.8	SCREW HC 3 X 3
Z706	1	U	VIS HC 3 X 10	SCREW HC 3 X 10
Z7063	2	U	COLONNE D: 20 LG: 61	COLUMN D: 20 L: 61

REFERENCE	QTY	UNIT	DESIGNATION	DESCRIPTION
Z732	1	U	VIS HC 6 X 6	SCREW HC 6 X 6
Z7351	2	U	VIS CHC 10 X 90	SCREW CHC 10 x 90
Z7377	2	U	PRISE SUB D FEMELLE 9 POINTS	PRISE SUB D FEMELLE 9 POINTS
Z739	1	U	VIS HC M6-35 - 8.8	SCREW HC 6 X 35
Z758	1	U	CONTRE PLAQUE	HAMMER GUIDE PLATE
Z759	1	U	GUIDE FIXE VOIR Z 10379	FIXED GUIDE (SEE Z10379)
Z7833	1	U	ETIQUETTE DE REPERAGE 11 A 20 BORNE WAGO	ETIQUETTE DE REPERAGE 11 A 20 BORNE WAGO
Z7834	1	U	ETIQUETTE DE REPERAGE 1 A 10 BORNE WAGO	ETIQUETTE DE REPERAGE 1 A 10 BORNE WAGO
Z7965	2	U	VIS CHC TETE BASSE M4-8 - 8.8	SCREW CHC 4 x 8 FLAT HEAD
Z7965	2	U	VIS CHC TETE BASSE M4-8 - 8.8	SCREW CHC 4 x 8 FLAT HEAD
Z8075	1	U	SELECTEUR DE CIRCUIT 1/4	SELECTOR 1/4
Z817	1	U	S/E AGRAFAGE ET GUIDE (mini cde 2 pcs)	Wedge distributor block (mini order 2 pcs)
Z8352	1	U	VIS FHC 5 X 40	SCREW FHC 5 x 40
Z863	1	U	BILLE D.8	BALL D.8
Z8761	1	U	BAGUE D'ETANCHEITE SD 30 X 40 X 4	AIRTIGHT RING SD 30x40x4
Z8768	2	U	CONTACT ELEC. BLOC NO	ELECTRIC CONTACT NO
Z8769	2	U	CONTACT ÉLEC. BLOC NF	ELECTRIC CONTACT NC
Z8797	2	U	VIS FHC 10 X 50	SCREW FHC 10 x 50
Z9160	1	U	ETIQUETTE SUPPORT IDENTITE MACHINES	ETIQUETTE SUPPORT IDENTITE MACHINES
Z9162	1	U	PLANCHE D'ETIQUETTES ASSEMBLEUSES	PLANCHE D'ETIQUETTES ASSEMBLEUSES
Z922	1	U	ECROU DE PRESSE ETOUPE N°16	NUT FOR STUFFING BOX N°16
Z928	1	U	DROIT 4 1/4	MALE TUBE CONNECTOR 4 1/4
Z944	1	U	MANOMETRE M 1/8	MANOMETER M 1/8
Z949	1	U	VIS TETE CARREE SPE. 6 X 20	SCREW SQUARE HEAD SPE. 6 x 20
Z9550	2	U	FIXATION CABLES 1/4 DE TOUR	CABLE ATTACHEMENT 1/4 OF TURN
Z97	1	U	VIS POINTEAU	SCREW POINT END
Z9791	2	U	RESSORT COMP D: 1.7 DE:16.5 - LO:40 6 SP	SPRING
Z9924	1	U	COLLIER SERRE CABLE D: 4.8	CABLE CLAMPING RING D: 4.8
Z9967	1	U	BOUCHON M 1/4 CYL	CAP M 1/4

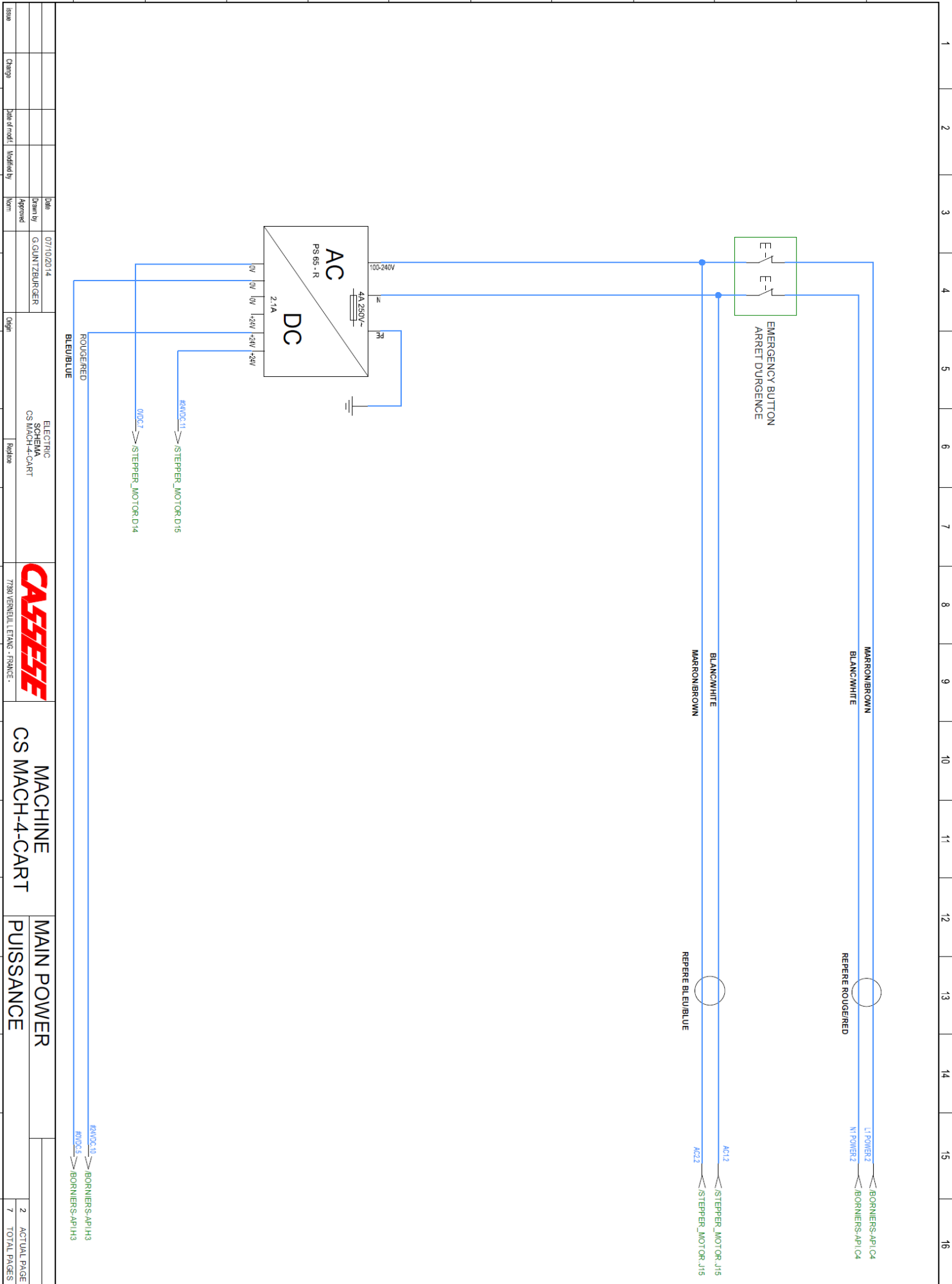
V.ELECTRICAL SCHEMATICS / SCHEMAS ELECTRIQUES

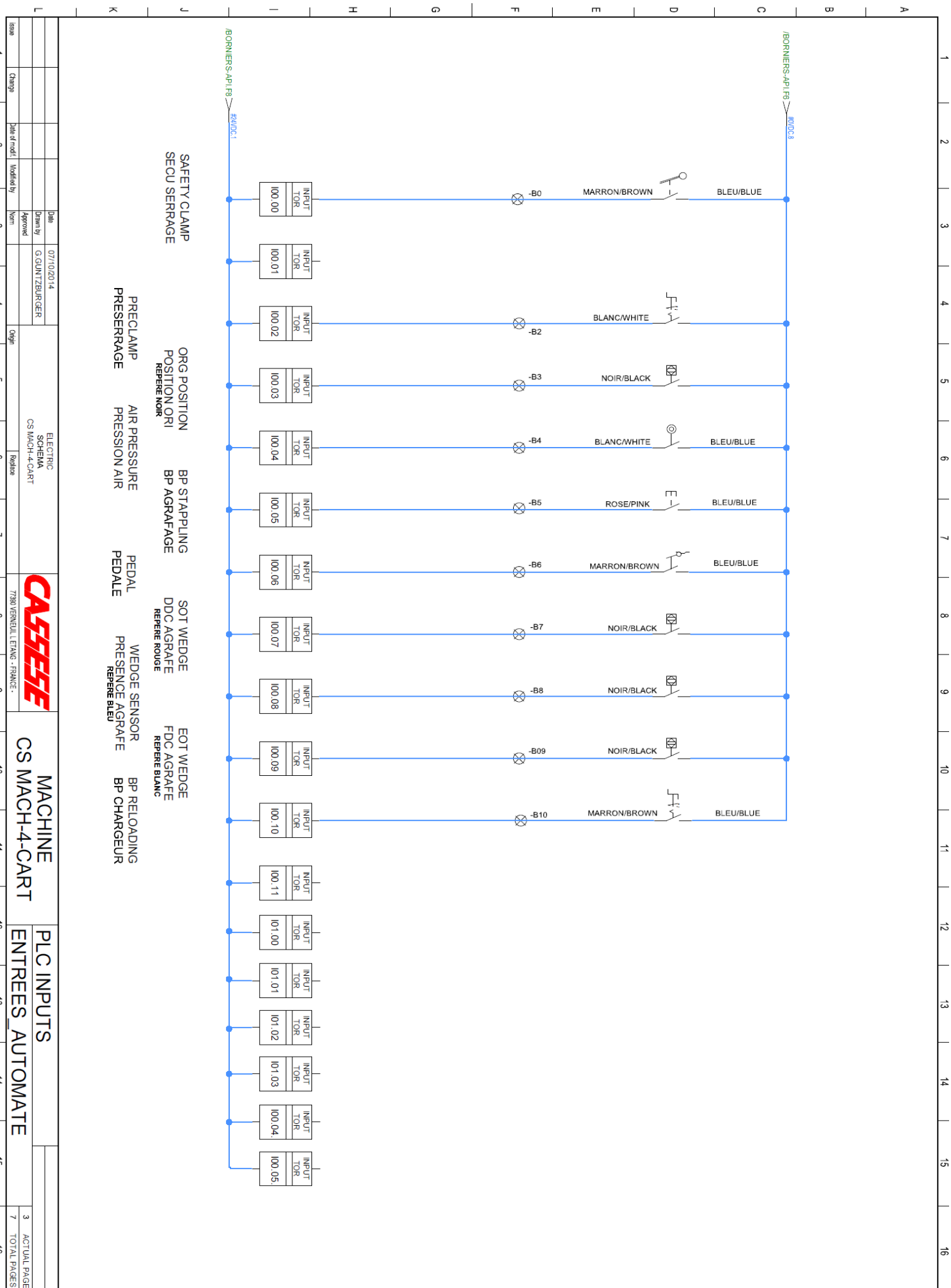
CASSESE CS MACH-4-CART
SCHEMA ELECTRIQUE
ELECTRIC DRAWING

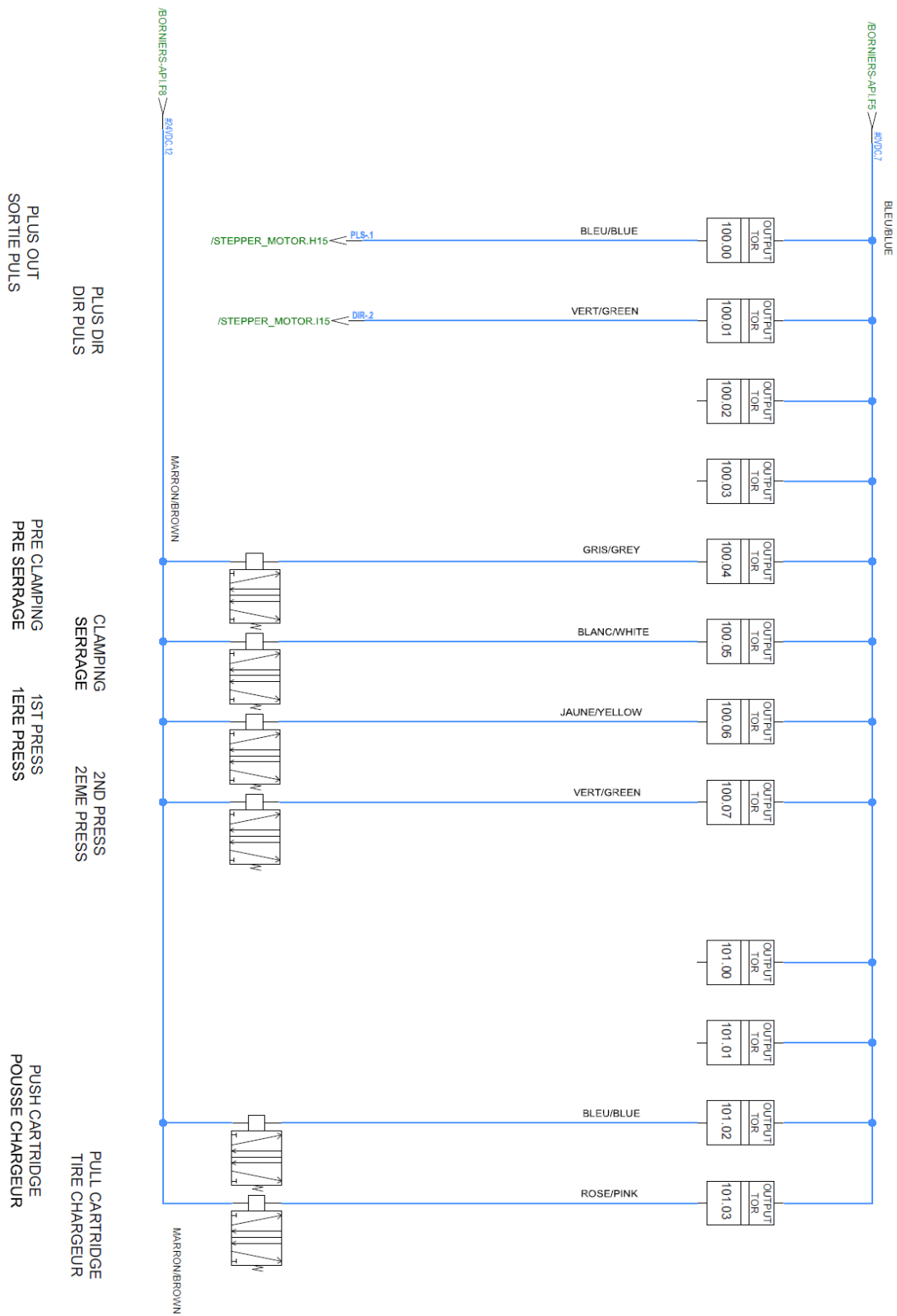
- 01 SOMMAIRE / SUMMARY
- 02 PUISSANCE / MAIN POWER
- 03 ENTREES AUTOMATE / PLC INPUTS
- 04 SORTIES AUTOMATE / PLC OUTPUTS
- 05 BORNIER - API / CONNECTORS - PLC
- 06 MOTEUR PAS A PAS / STEPPER MOTOR
- 07 PNEUMATIQUE / PNEUMATIC



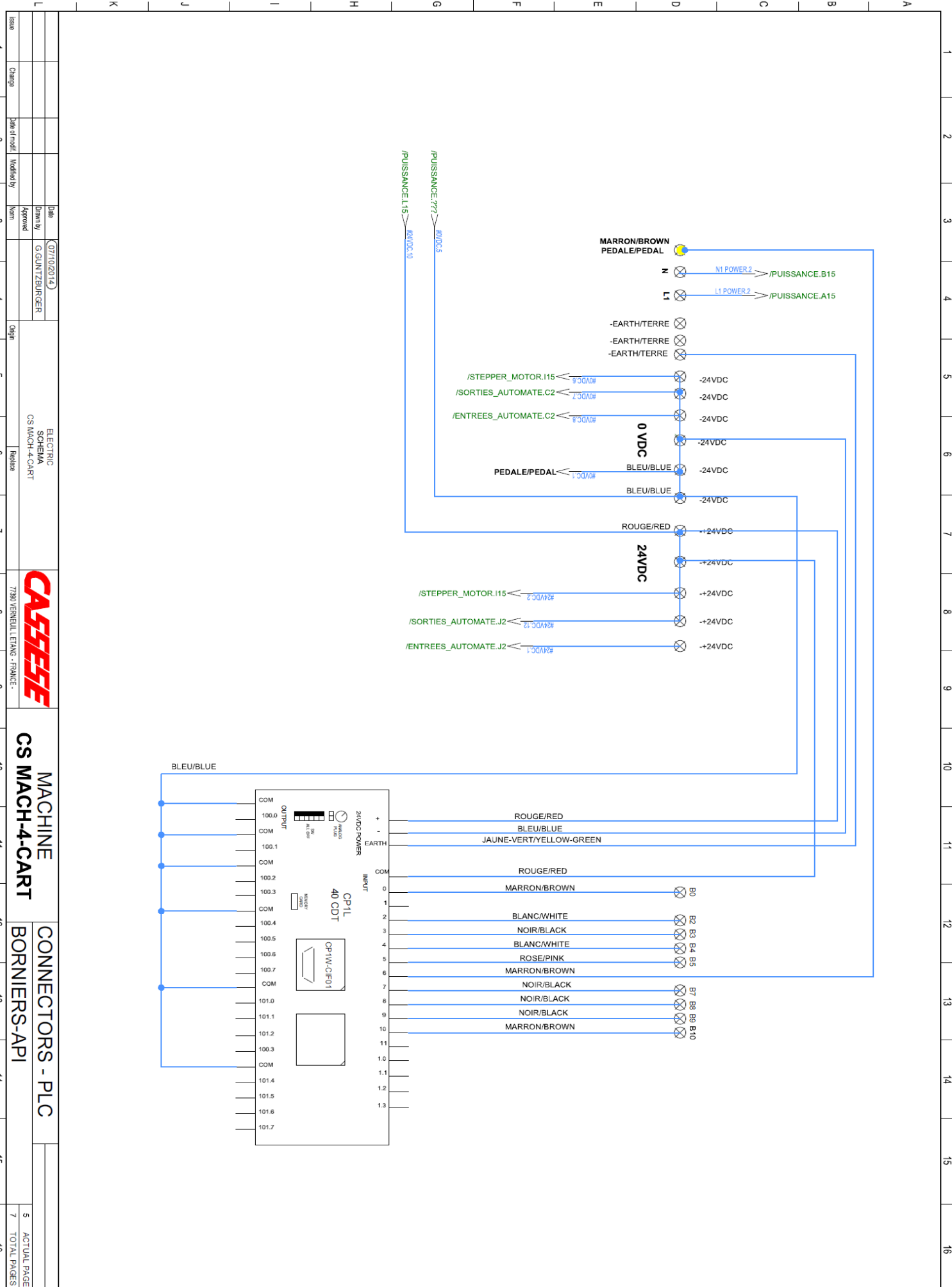
	Date	07/10/2014		MACHINE CS MACH-4-CART	SUMMARY		
	Drawn by	G.GUNTZBURGER					
	Approved						
	Drawn by						
	Version						
Change	Date of modif.	Modified by	Norm	Redise	77380 VERNILLI, L'ETANG - FRANCE -	1 ACTUAL PAGE	7 TOTAL PAGES

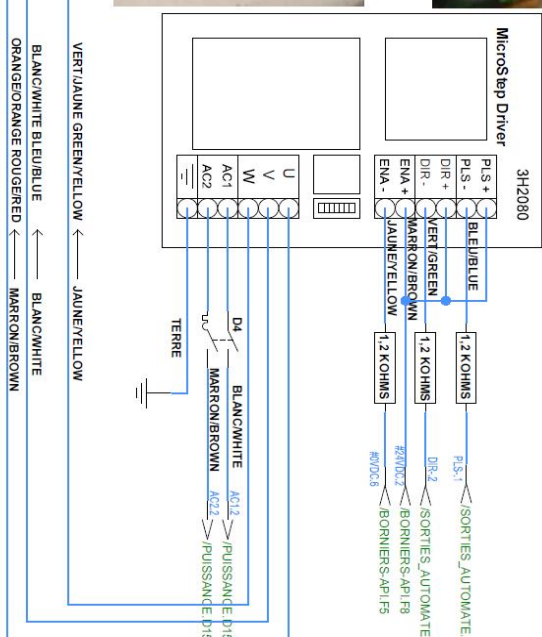
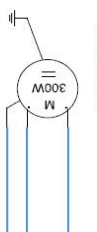
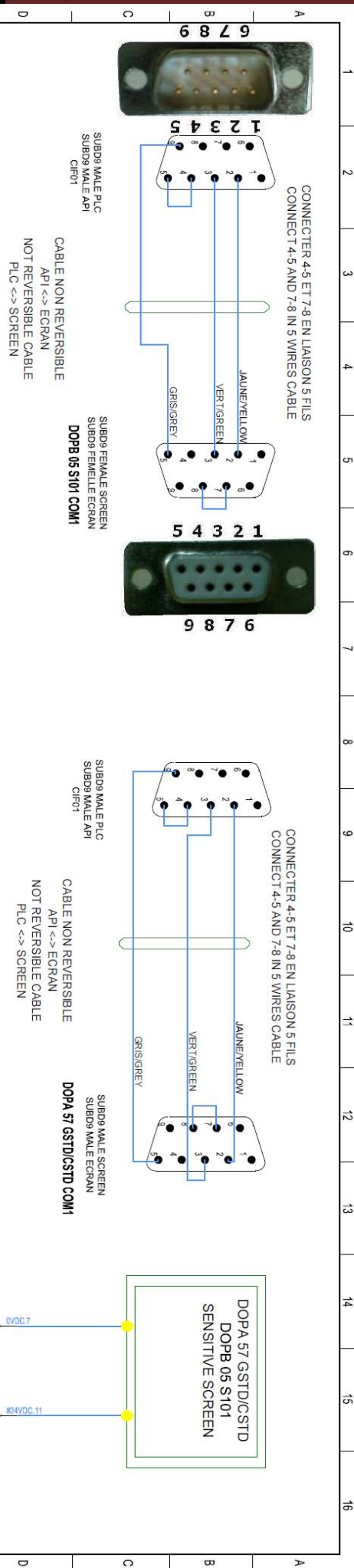






	Date	07/10/2014	ELECTRIC SCHEMA CS MACH-4-CART		MACHINE CS MACH-4-CART	PLC OUTPUTS	
	Drawn by	G.GUNTZBURGER					
	Approved						
	Date of model						
Change	Modified by	born				SORTIES AUTOMATE	
					7780 TERNELL ETANG - FRANCE -	4	ACTUAL PAGE
						7	TOTAL PAGES





Issue	Change	Date of modif.	Modified by	Hom.	Chgn	Replica	7780 VERNILLÉ ETANG - FRANCE -	MACHINE	NUMERIC STOP	STEPPER MOTOR	6 ACTUAL PAGE	7 TOTAL PAGES
1								CS MACH-4-CART				
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VI. CE CERTIFICATE / DECLARATION DE CONFORMITE

DECLARATION < CE > DE CONFORMITE

Le fabricant soussigné:

CASSESE SARL - 8 rue Denis Papin - zone industrielle

77390 Verneuil l' étang

France.

Déclare que la machine neuve désignée ci-après, est conforme:

- aux dispositions réglementaires définies par l'annexe 1 de la directive européenne:

" 2006/42/CE ".

- aux directives: "Equipements base tension " 2006/95/CE " Compatibilité électromagnétique:

" 2006/108/CE".

ASSEMBLEUSE D'AGRAFES :

-Electropneumatique.

MACH4CART : N° de série:

Fait à Verneuil l' Etang

Le: 01/09/2014

Le Gérant :

Z26838

